

Buck



CHUCKS

FOR

LATHES

DIVIDING HEADS

GRINDERS

BORING MACHINES

CHUCKING MACHINES

AUTOMATIC CHUCKERS

BRIERLY LOMBARD & CO., INC.
107-109 Foster St.
Worcester 8, Mass.
Phone 6-4325

Chuck Engineering Service that constantly improves precision and production

Chucks were chucks for 50 years until Buck entered the field with a new concept. It was a simple, but basic idea. As *workholding tools*, how could they be improved to do a better job?

That engineering approach has resulted in many Buck "firsts" that are practical and profitable in thousands of plants, both large and small.

Universal scroll chuck accuracy was improved from .003" to dead true precision, when desired. Rechucking within .0005" became routine.

Precision within .001" on power chucks, plus several advantages saving hundreds of man hours

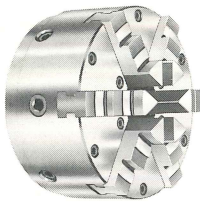
a year are greatly reducing production costs.

Dustproofing for chucks on grinders drastically reduces chuck replacement costs.

The latest Buck development triples the useful accuracy life of aluminum power chucks.

There is such a performance difference between conventional chucks and Buck Adjust-Tru® chucks, both manual and power, that it pays to consider Buck products as intended: in terms of specialized workholding tools. And to use the complete Buck chuck Engineering Service for the design and machining of top jaws for holding unusual shape parts.

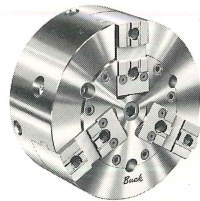
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First Precision Scroll Chuck—First 6-jaw Chuck

Before the Buck, .003" accuracy *when new* was the best you could expect from a universal scroll chuck. The Buck Adjust-Tru brought *dead true precision*0005" *guaranteed* precision chucking duplicate parts . . . compensation for spindle run out . . . longer lasting accuracy. The 6-jaw chuck, now unsuccessfully imitated, eliminates work "cocking," provides firmer grip without distortion, eliminates need for collets.

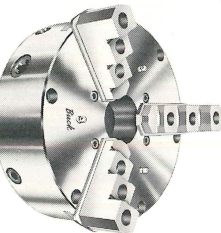
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First Adjust-Tru Power Chuck

Adapting the Buck Adjust-Tru principle to power chucks brought new precision and great time savings on automatic chucking operations. Now jaws can be finish-machined in the tool room. Hardened jaws are practical for all runs. Jobs can be run intermittently with no need to re-true jaws001" precision is guaranteed. You can save many hours of set-up time every month with Buck Power chucks.

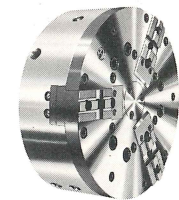
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First "Full Use" Dust Proof Chuck

Now you can get Buck Adjust-Tru precision in a dust proof chuck with center hole and full work-holding capacity. It gives you dead true precision on single parts — .0005" precision on duplicate parts — and minimizes the wear of abrasive dust and chips. Naturally it is particularly valuable on grinding machines and dividing heads. Will save many dollars a year on chuck replacement costs.

1
9
5
9



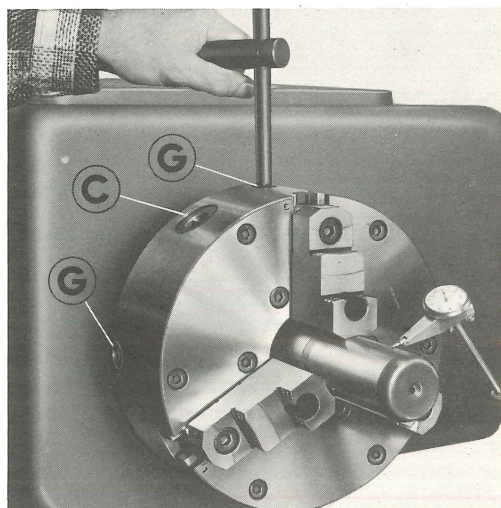
First Aluminum Power Chuck with Gibbed Keyways

Several outstanding advantages become available to you with this new Adjust-Tru aluminum body, gibbed keyway chuck. It guarantees precision within .001". Aluminum body and new design jaws provide 40% weight saving for easier starts and stops, less brake wear and maintenance. All moving parts are steel to steel. Two tapered gibs under each jaw take up wear to *triple* useful precision life and prevent "bell-mouthing". One-piece hardened front plate eliminates distortion. All working surfaces are hardened, ground, lubricated and can also be reconditioned in the tool room for longer life.

BUCK TOOL COMPANY

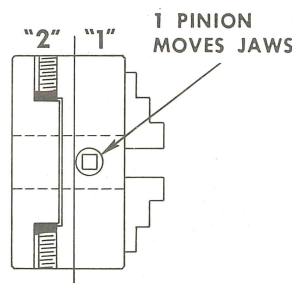
KALAMAZOO, MICHIGAN

How and Why you get precision chucking with the revolutionary Buck Ajust-Tru® principle



Buck chucks can be used for any conventional scroll chuck work and provide accuracy within .003". In addition, and this is the great advantage of the patented Buck Ajust-Tru principle, they can be adjusted for dead true precision, and on production runs guarantee precision within .0005" on duplicate parts. Note the diagram and photographs.

Turning pinion "C" in section "1" moves jaws in or out to grip work. Section "2" has a .020" clearance between chuck body and mounting plate hub, also 4 opposed adjusting screws "G". Precision adjustment is made by using the screws to move the whole chuck on the mounting plate. Machinists can line up work dead true within a minute. No further adjustment is needed to get precision within .0005" on duplicate parts. Changing to different diameter



parts may require an initial readjustment. To change from precision work back to ordinary scroll chucking you simply use the adjusting screws to make sure the chuck O.D. is running true.

The construction and the Buck Ajust-Tru® principle is further explained by this parts view. Jaws (A) ride on heat treated scroll (B) turned by pinion (C).

Front section of chuck body (D) and back section (E) are held together by six cap screws. Complete chuck body then fits over mounting plate hub (F) with .020" clearance. Six more cap screws hold the chuck to the mounting plate.

Opposed socket head screws (G) work on pressure plugs (H) against mounting plate hub (F) to shift the complete chuck to alignment.

To use as conventional .003" chuck, simply adjust body O.D. to run true.

U.S. Patent No. 2639157

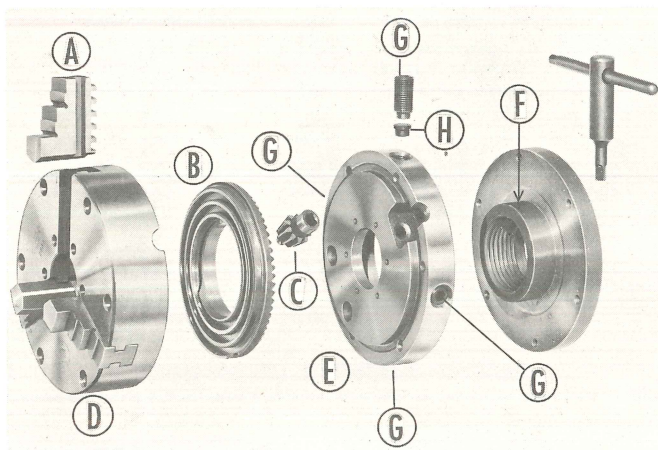


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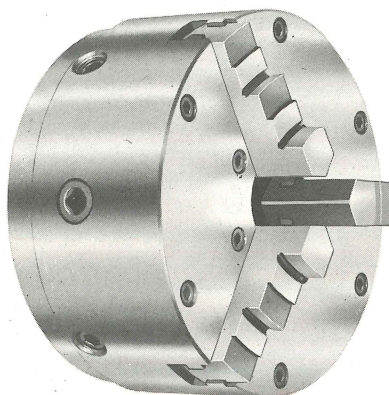
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GUARANTEE

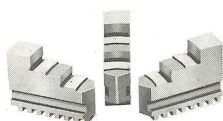
All Buck chucks are guaranteed for one year against defective materials or workmanship, provided they have not been abused in use. The Company reserves the right to repair or replace any part it judges to be defective—and assumes no responsibility for repair charges by others without written authorization. Chucks for repair must be sent prepaid—and will be returned prepaid.

AJUST-TRU

These were the original Buck developments that brought real precision in the use of universal scroll chucks.

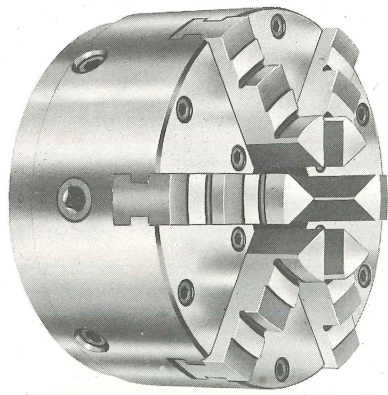


Includes inside and outside Jaws

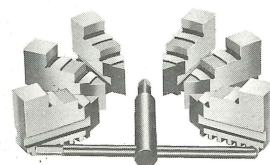


3-JAW Buck chucks are *six* times more accurate than conventional chucks, provide all their speed and flexibility, for the same cost. They eliminate the need to shift from 3 to 4 jaw chucks for precision work. When fitted with straight adapter can be chucked in a screw machine collet or larger chuck to increase accuracy or capacity of original equipment.

Chuck Number	Chuck Diameter	Jaw Width	Spindle Weight with Mtg. Plate
1434	4"	7/16"	7
2534	5"	5/8"	12
3634	6"	3/4"	21
4733	7 1/2"	7/8"	38
4831	8 1/4"	1"	51
5933	9"	1"	57
5103	10"	1 1/4"	73
5124	12"	1 1/2"	117



Includes inside and outside Jaws

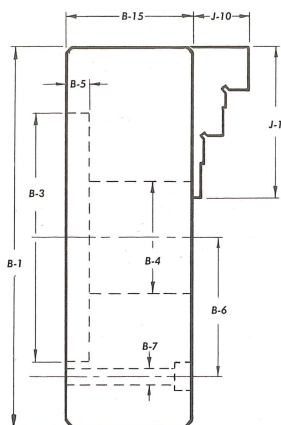


6-JAW You can center work easier and quicker with six opposed jaws. Soft metals and tubes can be gripped with less pressure, less distortion. Work is held firmer—permits precision machining farther from spindle. Eliminates need for collets. 6" size, for example, handles the work of 93 separate collets. Also takes work of odd and metric sizes.

Chuck Number	Chuck Diameter	Jaw Width	Spindle Weight with Mtg. Plate
1462	4"	7/16"	7
2562	5"	5/8"	12
3662	6"	3/4"	21
4761	7 1/2"	7/8"	39
4862	8 1/4"	1"	54
5961	9"	1"	59
5106	10"	1 1/4"	74
5127	12"	1 1/2"	119

GREASE FITTINGS CAN BE SUPPLIED — SEE PRICE LIST PAGE 2 (PARTS)

PRINCIPAL DIMENSIONS



	4"	5"	6"	7 1/2"	8 1/4"	9"	10"	12"
	1434-1462	2534-2562	3634-3662	4733-4761	4831-4862	5933-5961	5103-5106	5124-5127
B-1	4	5	6	7 1/2	8 1/4	9	10	12
B-3	2 1/8	2 3/8	3 1/8	3 3/8	4 3/8	4 3/8	6 3/8	7 7/8
B-4	1	1 1/4	1 1/2	2	2 1/4	2 1/2	2 3/4	3 1/4
B-5	1 1/16	2 1/32	1 1/16	3/4	3/4	3/4	1 3/16	1 3/16
B-6	1 9/64	2 7/32	2 43/64	3 3/8	3 3/4	4 3/32	2 3/16	2 5/8
B-7	7/32	9/32	9/32	1 3/32	1 3/32	1 3/32	1 5/32	1 7/32
B-15	1 11/16	2 1/16	2 5/16	2 3/4	3 1/8	2 7/8	3 1/2	4
J-1	1 5/16	1 7/8	2 1/2	3	3 1/2	3 1/2	3 5/8	4 1/4
J-10	3/4	3/4	1	1 5/16	1 3/8	1 3/8	1 3/4	1 3/4

MOUNTING PLATES SHOWN ON PAGES 7 & 8.

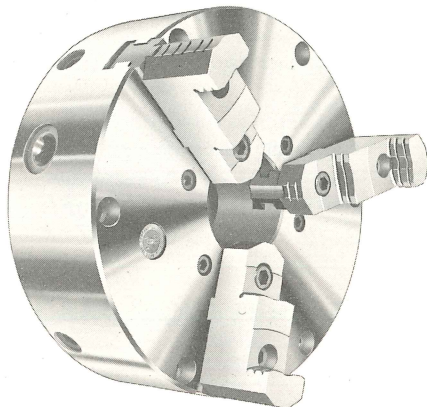
AJUST-TRU

Buck **AJUST-TRU** **CHUCKS**

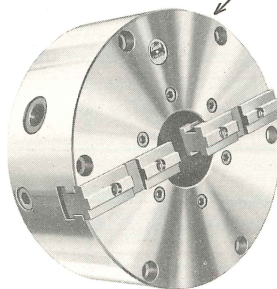
REVERSIBLE JAW

MASTER JAWS ONLY

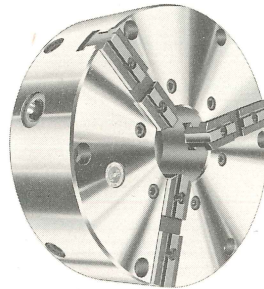
NOTE: Hardened reversible top jaws are **NOT AVAILABLE** for 2 and 6 Jaw Master Series



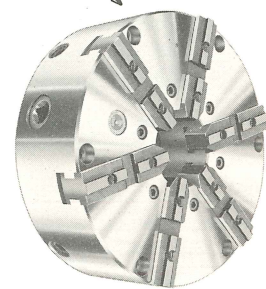
3-JAW



2-JAW



3-JAW



6-JAW

includes 3 Master and 3 Top Jaws

All operating advantages of regular Buck scroll chucks are provided by this reversible jaw chuck. In addition, of course, for work requiring specially machined jaws, you have the chuck and master jaws to hold them. See Page 9 for Blank Top Jaws.

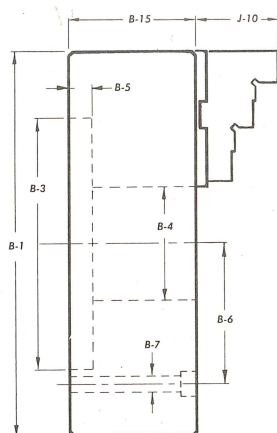
There is no problem now in securing dead true precision on work requiring machined jaws. The Buck Adjust-Tru principle takes care of that—and guarantees .0005" precision on duplicate parts. Jobs can be run intermittently, without re-truing top jaws, as final precision adjustment is made with the chuck. 2 and 6 Jaw Master Series, Use Blank Top Jaws *only*.

Chuck Number	Chuck Diameter	Master Jaw Width	Av. Spindle Weight with Mtg. Plate
2063R	6"	3/4"	22
2073R	7 1/2"	7/8"	39
2083R	8 1/4"	1"	52
2093R	9"	1"	58
2103R	10"	1 1/4"	75
2124R	12"	1 1/2"	120

2 Jaw Chuck No.	3 Jaw Chuck No.	6 Jaw Chuck No.	Chuck Dia.	Jaw Width	Av. Spindle Weight with Mtg. Plate
3623	2063	2066	6"	3/4"	20
4722	2073	2076	7 1/2"	7/8"	36
4822	2083	2086	8 1/4"	1"	49
5922	2093	2096	9"	1"	56
	2103	2106	10"	1 1/4"	67
	2124	2127	12"	1 1/2"	111

GREASE FITTINGS CAN BE SUPPLIED — SEE PRICE LIST PAGE 2 (PARTS)

PRINCIPAL DIMENSIONS

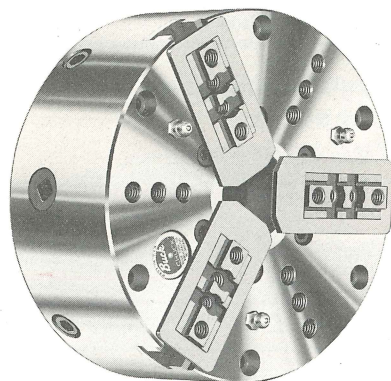


	6"	7 1/2"	8 1/4"	9"	10"	12"
B-1	6	7 1/2	8 1/4	9	10	12
B-3	3 3/8	3 5/8	4 3/4	4 3/4	6 3/8	7 7/8
B-4	1 1/2	2	2 1/4	2 1/2	2 3/4	3 1/4
B-5	1 1/16	3/4	3/4	3/4	13/16	13/16
B-6	2 43/64	3 3/8	3 3/4	4 3/32	2 3/16	2 5/8
B-7	9/32	13/32	13/32	13/32	15/32	17/32
B-15	2 5/16	2 3/4	3 1/8	2 7/8	3 1/2	4
*J-10	1 1/2	2	2 1/32	2 1/32	2 17/32	2 17/32

*For numbers ending in "R" only.

MOUNTING PLATES SHOWN ON PAGES 7 & 8.

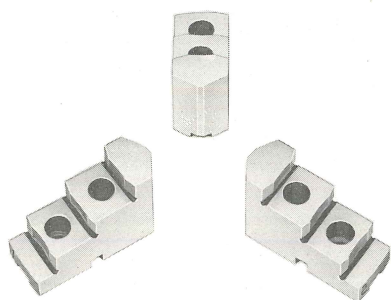
NEW DUST-PROOF CHUCK



This is the first dust-proof universal scroll chuck with center hole, full work-holding capacity and minimum overhang. It gives you regular Buck Ajust-Tru precision on grinding machines and dividing heads with minimum wear from abrasive dust and chips.

Working parts are protected in three ways. First, the bushing around the center hole seals off internal keyway ends. Second, new Buck *dust plates* seal off the slots under the jaws. Third, jaw slots are sealed at outside ends.

The top jaws can be positioned on the master jaws as necessary for different diameter work so that there is no interference with the normal work-holding capacity of the chuck. This new chuck can save many dollars a year on chuck replacement costs where abrasive dusts usually cause rapid chuck wear.



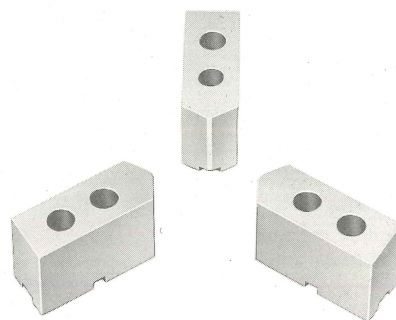
Stepped Top Jaws

Chuck Number	Chuck Diameter	Spindle Weight with Mtg. Plate
2063DP	6"	21
2093DP	9"	56
2124DP	12"	123

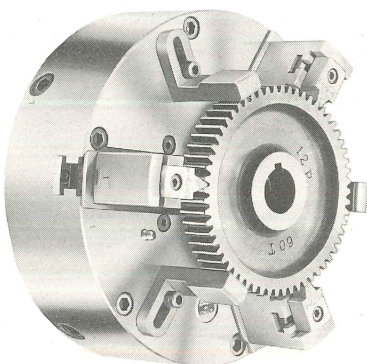
Ordering Jaws

One set of **STEPPED TOP JAWS** is supplied with each chuck. To re-order, be sure to specify both the kind of jaws and the chuck number.

BLANK SOFT TOP JAWS are sent on special order only. Again—be sure to specify chuck number.



Blank Soft Top Jaws



GEAR CHUCK

This is a further development of the Dust Proof chuck. It is the *only* chuck that gives you broad capacity in holding gears of different diameters (see chart below)—and holds perfect gears *within .0005" precision on the pitch line*. As a result of the broad capacity, angulate pitch blocks for both spur and helical gears, and simplicity of use, Buck gear chucks are reducing operating steps and scrap in many plants. Chucks include: Loading guides, gear pitch top jaws, one set of gear pitch blocks and gauge with one plug.

Chuck Number	Chuck Diameter	Spindle Weight with Mtg. Plate
2063DPG	6"	22
2093DPG	9"	57
2124DPG	12"	125

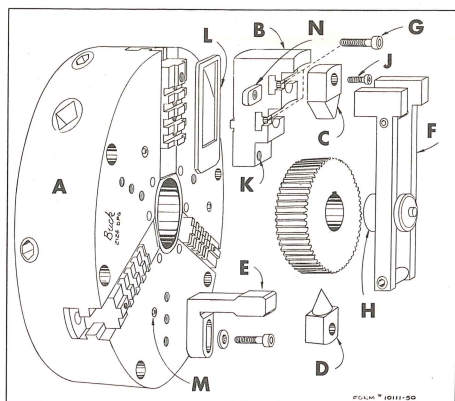
Gear Chuck Parts List

Chuck Sizes	6"	9"	12"
"T" slot jaw (B)—set of 3	A-10659	A-10617-1	10839-2
Loading Guides (E) set of 3	10666	10643	10856
Pitch Blocks—specify (C) Spur, or (D) Helical gears and Pressure Angle—14 1/2° or 20°—set of 3	A-10679	A-10679	10838
Gauge (F) with one plug—state (H) size	A-10588	A-10588	A-10874
	6"	9"	12"
Maximum standard diameter and pitch	4.228D-8P	7.135D-8P	10.774D-4P
Minimum standard diameter and pitch	.208D-48P	1.303D-48P	1.091D-48P

Extra gauge plugs are available—see price list.

Special diameters and jaw shapes available on special order—send gear prints showing machining desired for quotation.

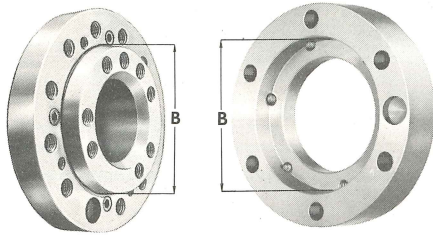
Note that machine clearances are important as the gear jaws may have to protrude from the O.D. of chuck.



AJUST-TRU

MOUNTING PLATES FOR STANDARD SPINDLES
Require Little or No Fitting by You . . . Plates for Same size chucks are interchangeable

AMERICAN STANDARD TYPES A-1 and A-2

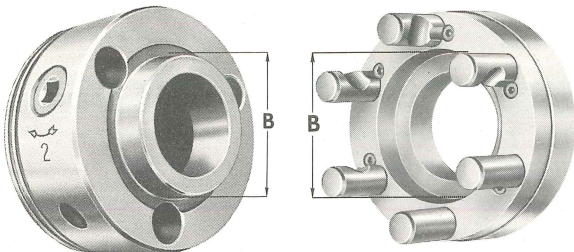


Nose	"B" Diam. ‡	ORDER NUMBER FOR CHUCK SIZE					
		6"	7½"	8¼"	9"	10"	12"
3"	2⅛"	A-300	A-350	*	*	*	*
4"	2½"	A-301	A-351	A-306	A-361	*	*
5"	3¼"	A-302	A-352	A-307	A-362	*	*
6"	4⅜"	**	A-353	A-308	A-363	A-312	A-315
8"	5½"	**	**	**	**	A-313	A-316
11"	7¾"	**	**	**	**	**	A-317

*Chuck too large for spindle

**Spindle too large for chuck

CAMLOCK TYPE D-1

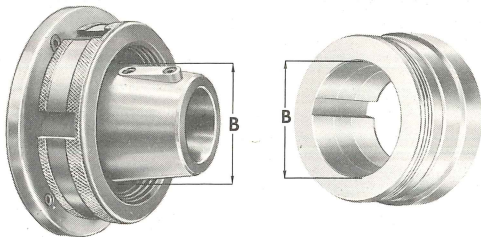


Nose	"B" Diam. ‡	ORDER NUMBER FOR CHUCK SIZE					
		6"	7½"	8¼"	9"	10"	12"
3"	2⅛"	C-203	C-254	*	*	*	*
4"	2½"	C-201	C-251	C-204	C-222	*	*
5"	3¼"	C-202	C-252	C-208	C-262	*	*
6"	4⅜"	**	C-253	C-209	C-263	C-211	C-214
8"	5½"	**	**	C-207	C-264	C-212	C-215

*Chuck too large for spindle.

**Spindle too large for chuck

LONG TAPER KEY DRIVE TYPE L

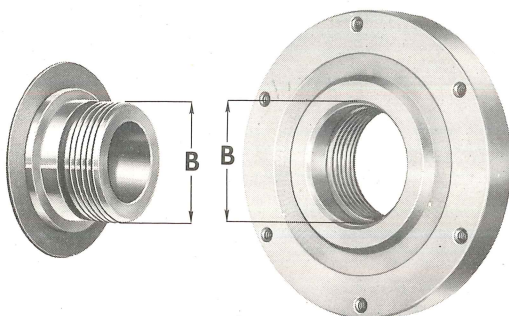


Nose	"B" Diam. ‡	ORDER NUMBER FOR CHUCK SIZE					
		6"	7½"	8¼"	9"	10"	12"
L-00	2¾"	L-100	L-150	L-108	L-160	*	*
L-0	3¼"	L-101	L-151	L-109	L-161	L-112	L-115
L-1	4⅛"	**	**	L-110	L-162	L-113	L-116
L-2	5¼"	**	**	**	**	L-114	L-166

*Chuck too large for spindle

**Spindle too large for chuck

THREADED MOUNTING PLATES



"B" ‡		ORDER NUMBER FOR CHUCK SIZE							
		4"	5"	6"	7½"	8¼"	9"	10"	12"
1" - 8	T-900	T-925	*	*	*	*	*	*	*
1" - 10	T-901	T-926	*	*	*	*	*	*	*
1" - 12	T-902	T-927	*	*	*	*	*	*	*
1½" - 8	T-903	T-928	T-950	*	*	*	*	*	*
1¾" - 8	T-904	T-929	T-951	*	*	*	*	*	*
2¼" - 8	**	**	T-955	T-978	T-985	T-990	T-994	*	*
2⅝" - 6	**	**	T-958	T-981	T-986	T-991	T-995	T-997	*
2¾" - 8	**	**	**	**	T-988	T-993	T-989	T-999	*
semi-finished	T-905	T-931	T-959	T-982	T-987	T-992	T-996	T-998	*

*Chuck too large for spindle

**Spindle too large for chuck

For other sizes or pitched plates fitted by us, an accurate drawing giving pitch, diam. is needed.

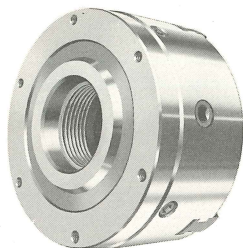
‡"B" dimensions are large diameter of pilots

The Buck design of chuck body and functional mounting plate insures spindle mounting to match the running or turning characteristic of any spindle. Simply position mounting plate on spindle, indicate chuck side of mounting plate and take light truing cut if more than .0005" error is indicated.

IMPORTANT: BE SURE TO GIVE MAKE, MODEL, SIZE OF MACHINE WHEN ORDERING MOUNTING PLATES

SPECIAL CHUCKS and MOUNTING PLATES

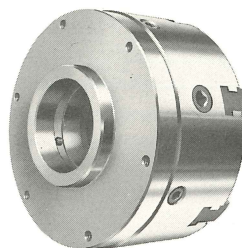
Self-centering scroll chucks fitted for Hardinge and Elgin $2\frac{3}{16}$ "-10th type spindles.



Chuck No.	Chuck Diam.	Spindle Wt.
2534H	5"-3 Jaw	11
2562H	5"-6 Jaw	11
3634H	6"-3 Jaw	19
3662H	6"-6 Jaw	19

5" chucks are special and have to be ordered from factory. 6" chucks are standard.

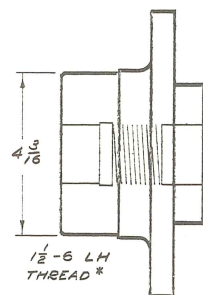
Self-centering scroll chucks fitted for Hardinge and Elgin 4° taper type spindles.



Chuck No.	Chuck Diam.	Spindle Wt.
2534-HT	5"-3 Jaw	11
2562-HT	5"-6 Jaw	11
3634-HT	6"-3 Jaw	19
3662-HT	6"-6 Jaw	19

5" chucks are special and have to be ordered from factory. 6" chucks are standard.

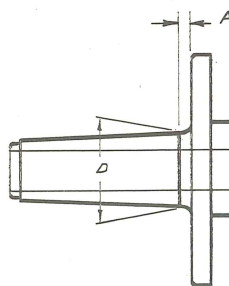
Mountings for Brown and Sharpe No. 13 grinder, pulley type with $1\frac{1}{2}$ "-6th L.H. spindle.



(For Serial 6325 and higher only)

Mounting Plate No.	Chuck Size	Spindle Wt.
S-132	4" Univ.	3
S-192	5" Univ.	4
S-131	6" Univ.	5
S-358	7 1/2" Univ.	9
S-349	6" Ind. L.D.	5
S-350	8" Ind. L.D.	10

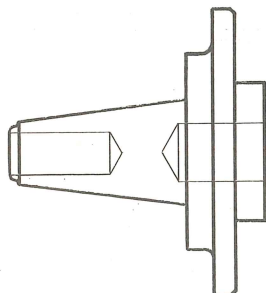
Mountings for No. 12 B & S and No. 5 M.T. spindles.



Mounting Plate No.	Taper	Chuck Size	"D"	"A"	Spindle Wt.
S-296	#5MT	4" Univ.	1.754"	1/8"	3
S-302	#12BS	4" Univ.	1.800"	1/8"	3
S-297	#5MT	5" Univ.	1.754"	1/8"	4
S-303	#12BS	5" Univ.	1.800"	1/8"	4
S-298	#5MT	6" Univ.	1.754"	1/8"	7
S-299	#12BS	6" Univ.	1.800"	1/8"	7
S-359	#5MT	4" Ind. L.D.	1.754"	1/8"	3
S-282	#12BS	4" Ind. L.D.	1.800"	1/8"	3
S-359	#5MT	6" Ind. L.D.	1.754"	1/8"	3
S-282	#12BS	6" Ind. L.D.	1.800"	1/8"	3

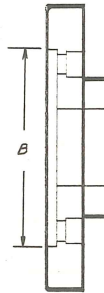
#11 B & S Also available.

Mountings for Nos. 40 and 50 mill taper spindles. Taper mounting.



Mounting Plate No.	Chuck Size-Type	Taper No.	Spindle Wt.
S-333	6"-Ind. L.D.	40	2
S-280	6"-Ind. M.D.	50	6
S-247	6"-Univ.	40	8
S-246	6"-Univ.	50	9
S-245	7 1/2"-Univ.	50	15
S-379	8"-Univ.	50	18
S-829	8"-Ind. M.D.	50	13
S-237	9"-Univ.	50	20

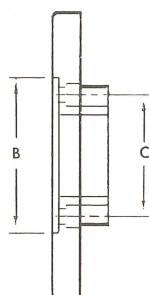
*Mounting plates for Nos. 40 and 50 mill taper spindles. Flange mounting.



Mounting Plate No.	Chuck Size-Type	Taper No.	"B"	Spindle Wt.
S-337	6"-Ind. L.D.	40	3 1/2"	6
S-262	6"-Ind. M.D.	50	5"	6
S-139	6"-Univ.	40	3 1/2"	6
S-264	6"-Univ.	50	5"	6
S-259	7 1/2"-Univ.	50	5"	9
S-265	8"-Univ.	50	5"	13
S-830	8"-Ind. M.D.	50	5"	12
S-266	9"-Univ.	50	5"	16

* PLATES WITH 3 BOLT HOLES AVAILABLE, STANDARD HAVE 4 BOLT HOLES.

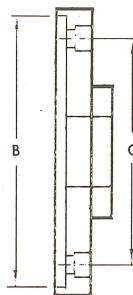
Mounting Plates Standard For Many Boring Machines Using Universal Chucks



Mounting Plate No.	Chuck Diam.	B Diam.	C Diam.	Machine No.	Spindle Wt.
S-341	6"	4"	3 1/8"	Heald and Bryant #209 or #212	5
S-181	7 1/2"	4"	3 1/8"	Heald and Bryant #216	7
S-342	6"	5 5/8"	4 5/8"	Heald and Bryant #216	5
S-182	7 1/2"	5 5/8"	4 5/8"	Heald and Bryant #216	7
S-343	5"	3"*	3 5/8"	Exello DB-8	4
S-135	6"	3"*	5"	Exello DB-8	5

*Female Type Spindle Pilot.

Mounting Plates Standard for Many Heald Internal Grinders.



Mounting Plate No.	Chuck Size-Type	B Pilot	C Bolt Circle	Spindle Wt.
S-344	6" Univ.	9 5/8"	8"	19
S-345	7 1/2" Univ.	9 5/8"	8"	22
S-190	9" Univ.	9 5/8"	8"	26
S-346	7 1/2" Univ.	11"	9"	23
S-347	9" Univ.	11"	9"	27
S-348	10" Univ.	11"	9"	30

AJUST-TRU PARTS LIST

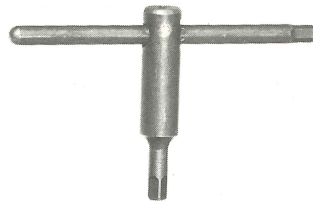
ORDERS FOR PARTS MUST INCLUDE NUMBER ON CHUCK FACE



SCROLL



PINION



WRENCH



PINION
RETAINER



ADJUSTING SCREW

PRESSURE PLUG

PART NAMES

Scroll
Pinion
Wrench
Pinion Retainer
Pressure Plugs
Adjusting Screws
Mounting Screws
(outside diam.)
Chuck Screws
(inside diam.)

IMPORTANT

When ordering chuck parts, select part required from above and identify the number stamped on chuck face.









EXAMPLE: One (1) pinion for a No. 3634 chuck.

FRONTS AND BACKS MUST BE FITTED AT FACTORY

ORDER NUMBERS for EXTRA JAWS, MASTER JAWS, AND SOFT TOPS . . . ORDERS MUST INCLUDE NUMBER ON CHUCK FACE

Jaw dimensions on Page 10

Where original chuck accuracy is required it is recommended that one piece jaws and master jaws be fitted at factory. Charge is nominal.

								2-Jaw models have square ends. 3 and 6 are pointed.
Style No. 1 OUTSIDE JAW For 3 Jaw Chuck only	Style No. 2 INSIDE JAW For 3 Jaw Chuck only	Style No. 8 OUTSIDE JAW For 6 Jaw Chuck only	Style No. 9 INSIDE JAW For 6 Jaw Chuck only	Style No. 5 SOFT BLANK JAW ★	Style No. 6M MASTERS ★	3-JAW ONLY Style No. 3T HARD REVERSIBLE TOP JAWS ★	Style No. 7 SOFT TOPS ★	

★—State number of Jaws on chuck—2, 3, or 6

CHUCK SIZE

4"
5"
6"
7½"
8¼"
9"
10"
12"

IMPORTANT

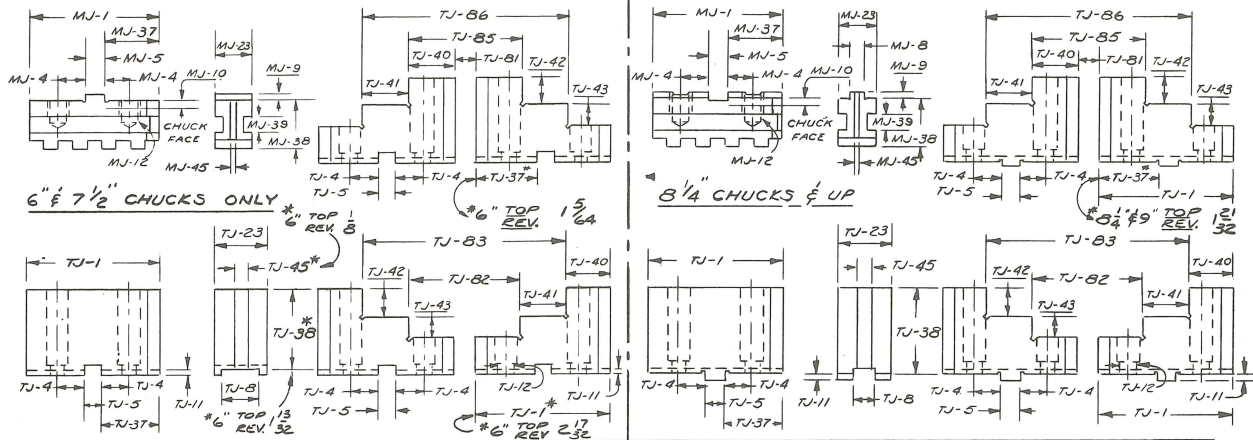
When ordering jaws, select style number from above and identify the number stamped on chuck face.

EXAMPLE: One (1) set of three Style No. 2 inside jaws for a No. 3634 chuck.

SPECIAL TOP JAWS — OR CHUCKS — FOR SPECIAL PARTS

An important part of Buck Company service includes (1) supplying top jaws machined to size for holding special parts and (2) designing and building complete chucks for holding special parts. In writing for information about this service include print of piece to be held and data about production machine.

PRACTICAL DIMENSIONS and CAPACITIES FOR HARDENED MASTER and TOP REVERSIBLE JAWS



CHUCK	MJ-1	MJ-4	MJ-5	MJ-8	MJ-9	MJ-10	MJ-12	MJ-23	MJ-37	MJ-38	MJ-39	MJ-45
6	2 1/2	2 1/32	.375		3/32	1/8	5/16-18	.7385	1 1/16	29/32	.3100	3/64
7 1/2	3	2 1/32	.375		3/32	5/32	5/16-18	.8635	1 5/16	1 5/32	.3740	1/8
8 1/4	3 1/2	5/8	.499	.3125	1/8	11/64	3/8-16	.9510	1 3/8	1 1/8	.4370	1/4
9	3 1/2	5/8	.499	.3125	1/8	11/64	3/8-16	.9510	1 3/8	1 1/8	.4370	1/4
10	3 5/8	1 1/16	.749	.500	1/8	1/8	1/2-13	1.2345	1 17/32	1 3/8	.4995	1/2
12	4 1/4	7/8	.749	.500	1/8	5/64	1/2-13	1.4845	1 27/32	1 11/32	.4995	1/2

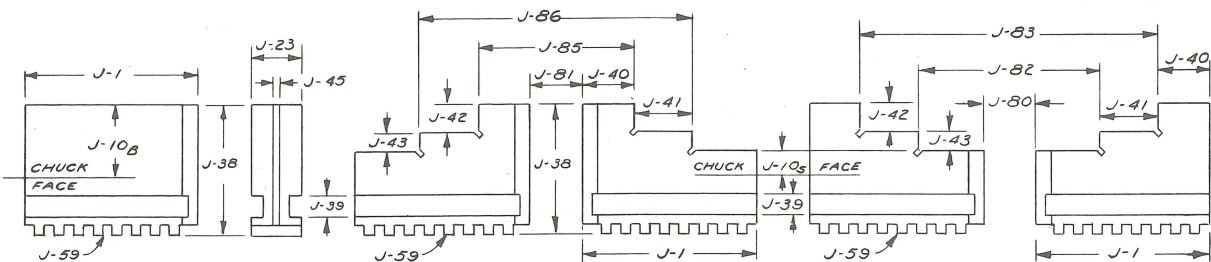
CHUCK	TJ-1	TJ-4	TJ-5	TJ-8	TJ-11	TJ-12	TJ-23	TJ-37	TJ-38	TJ-40	TJ-41	TJ-42	TJ-43	TJ-45	TJ-81	TJ-82	TJ-83	TJ-85	TJ-86
6	2 3/4	2 1/32	.375	.739	3/32	1 1/32	1 1/8	1 1/8	3/4	1	1/2	5/16	1 1/8	1 1/8	3/16	3/16	1 1/16	5/16	3 1/16
7 1/2	3 1/8	2 1/32	.375	.864	1/8	1 1/32	1 1/4	1 3/8	1 1/8	1 1/8	1	5/8	1/2	1/4	2 1/2	5/16	4 5/8	2 1/2	6 5/8
8 1/4	3 9/16	5/8	.499	.315	1/8	1 3/32	1 1/4	1 13/32	1 1/8	3/4	1 1/2	5/8	1 1/16	1/4	2 3/16	5/16	5 1/4	2 15/16	8 1/4
9	3 3/8	5/8	.499	.315	1/8	1 13/32	1 1/4	1 13/32	1 1/8	3/4	1 1/2	5/8	1 1/16	1/4	2 3/16	5/16	6	2 15/16	9
10	3 3/4	1 1/16	.749	.501	1/8	1 13/32	1 1/2	1 19/32	2 3/8	1 5/8	1 1/4	1 1/16	1 1/16	5/8	4 1/4	3/4	7 3/8	3 13/16	9 1/16
12	4 3/8	7/8	.749	.501	1/8	1 13/32	1 3/4	1 29/32	2 3/8	1 5/8	1 1/4	1 1/16	1 1/16	5/8	5	3/4	8 3/8	4 9/16	11 3/16

REVISED 7/1/60

FORM #10111-24

JN

FOR STEP TYPE and SOFT BLANK JAWS



CHUCK	J-1	J-108	J-23	J-38	J-39	J-40	J-41	J-42	J-43	J-45	J-59
4	1 9/16	3/4	1 5/64	.4295	1 1/4	.1765	27/64	5/8	17/64	1/4	.020 5 T.P.I.
5	1 27/32	49/64	1/8	.6175	1 1/2	.2475	5/8	5/8	17/64	1/32	3 1/2 T.P.I.
6	2 1/2	31/32	9/32	.7385	1 3/4	.3100	3/4	7/8	3/8	3/64	3 1/2 T.P.I.
7 1/2	3	1 1/4	1/2	.8635	2 1/4	.3740	7/8	1	7/16	1/8	3 T.P.I.
8 1/4	3 1/2	1 13/32	11/32	.9510	2 5/16	.4370	1	1 1/2	19/32	1/8	3 T.P.I.
9	3 1/2	1 13/32	11/32	.9510	2 5/16	.4370	1	1 1/2	19/32	1/8	3 T.P.I.
10	3 5/8	1 25/32	5/16	1.2345	3	.4995	1	1 1/4	25/32	1 1/16	3 T.P.I.
12	4 1/4	1 25/32	9/32	1.4845	3	.4995	1 1/4	1 1/4	13/16	1 1/16	2 1/2 T.P.I.

CHUCK	MAX. J-80 MIN.	MAX. J-81 MIN.	MAX. J-82 MIN.	MAX. J-83 MIN.	MAX. J-85 MIN.	MAX. J-86 MIN.
4		1 1/2	1/8	2 1/2	1 1/8	3 3/4
5		1 5/8	1/8	2 3/4	1 3/8	4
6	1 7/8	1/8	1 7/8	1/8	3 5/8	1 7/8
7 1/2	2 3/4	3/16	2 3/4	3/16	5	2 3/8
8 1/4	2 3/4	1/4	2 3/4	1/4	5	2 1/4
9	3 1/2	1/4	3 1/2	1/4	5 3/4	2 1/4
10	4 1/4	3/4	4 1/4	3/4	7	3 1/2
12	5	3/4	5	3/4	8 1/2	4 1/4

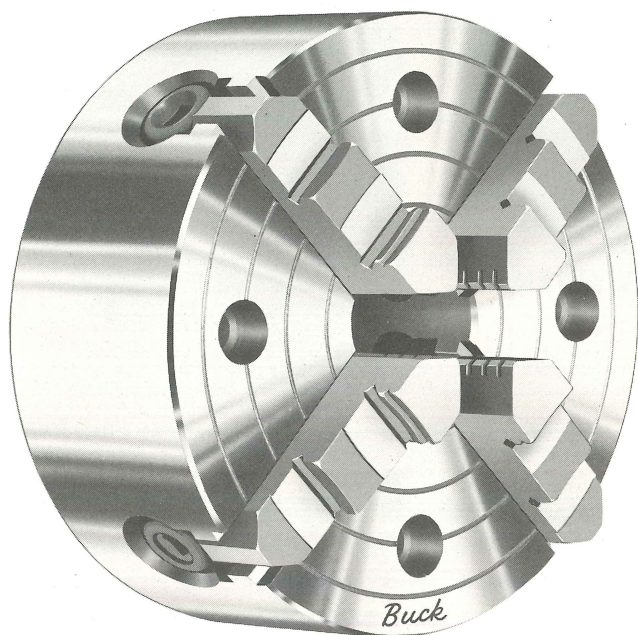
FORM #10111-25

BUCK TOOL COMPANY
KALAMAZOO, MICHIGAN

Buck

INDEPENDENT

CHUCKS



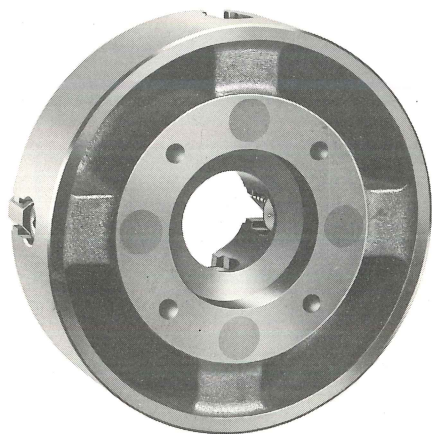
MEDIUM DUTY

The introduction of Buck Independent chucks marked a further step forward in chuck design that improves performance. It enables Medium Duty chucks to be used frequently for some kinds of cuts normally scheduled for heavy duty chucking.

Buck Medium Duty chucks have a $\frac{5}{8}$ " recess in the back, which automatically reduces overhang by that amount, brings work that much closer to the spindle for greater rigidity, greater stability, and greater accuracy.

All Medium Duty chucks are made of semi-steel. They are performing successfully in thousands of plants throughout the nation.

ALL INDEPENDENT CHUCK JAWS ARE REVERSIBLE. 2-piece jaws not available.



This shows the recessed back — a feature of all Buck Independent chucks.

It reduces overhang by approximately $\frac{5}{8}$ ". Bringing work that much closer to the spindle promotes greater accuracy, permits heavier cuts.

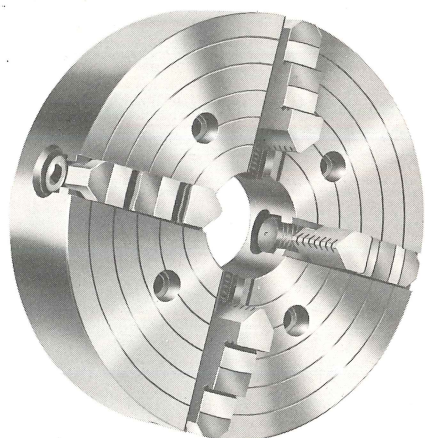
(The cored back of the Light Duty chuck is shown. Medium Duty has solid back.)

LIGHT DUTY

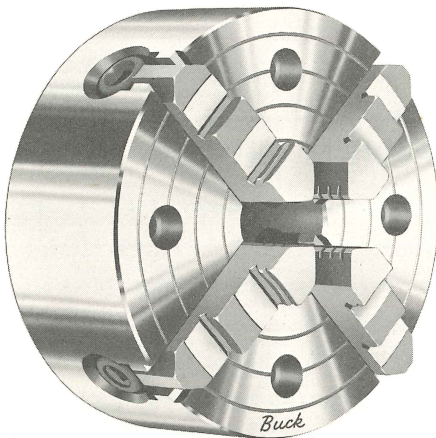
Most chucks for 9" to 13" lathes are either too lightly made to hold work accurately, or too heavy for the machines and clumsy to use. Buck Light Duty Independent chucks end this difficulty.

In each diameter these chucks have been carefully proportioned for the machines on which they are likely to be used, and the work to be done. Buck Light Duty chucks are particularly useful on grinders and dividing heads.

As shown by the illustration at the left, Buck Light Duty chucks have the conventional keyway construction. 4" and 6" diameters are made of steel. 8" and 10" diameters are made of Meehanite.



Buck INDEPENDENT CHUCKS



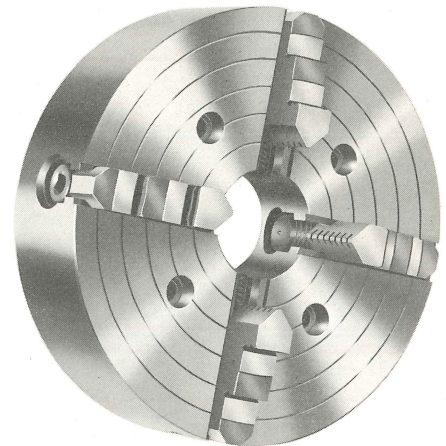
MEDIUM DUTY

More rigidity, more stability, more accuracy is the performance story of these special design Buck chucks.

They are made of semi-steel and guaranteed to give you precision work on every job within their capacity.

FOR
INTERMEDIATE
MOUNTING PLATES
SEE PAGE 14

JAWS ARE REVERSIBLE



LIGHT DUTY

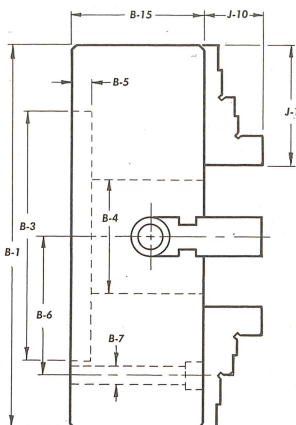
The complete description of these chucks is on the preceding page. Though called "light duty" the smaller diameters could be considered "heavy duty" in appearance and performance. 4" and 6" chucks have steel bodies. 8" and 10" sizes are made of Meehanite.

Chuck Number	Chuck Diameter	Jaw Width	Spindle Weight
1306	6"	3/4"	16
1308	8"	1"	34
1310	10"	1"	55
1312	12"	1 1/2"	111

Chuck Number	Chuck Diameter	Jaw Width	Spindle Weight
1144	4"	5/8"	6
1164	6"	5/8"	13
1284	8"	3/4"	20
1104	10"	3/4"	28

PRINCIPAL DIMENSIONS

	MEDIUM DUTY					LIGHT DUTY			
	6"	8"	10"	12"		4"	6"	8"	10"
	1306	1308	1310	1312		1144	1164	1284	1104
B-1	6	8	10	12	B-1	4	6	8	10
B-3	3.100 3.099	6.312 6.313	6.312 6.313	7.750 7.751	B-3	3.126 3.125	3.126 3.125	3.099 3.100	3.099 3.100
B-4	1 1/2	2 1/8	3	3 1/2	B-4	1	1 1/2	2	2 1/4
B-5	1 3/32	2 1/32	1 1/16	1 1/16	B-5	1/8	1/8	1 1/16	1 1/16
B-6	2 1/16	2 5/8	2 5/8	3 3/8	B-6	1 5/16	1 5/16	2 1/16	2 1/16
B-7	2 5/64	3 3/64	3 3/64	2 1/32	B-7	2 1/64	2 1/64	1 3/32	1 3/32
B-15	2 3/8	3	3 1/32	3 1/2	B-15	1 21/32	1 21/32	2 1/4	2 1/4
J-1	2 1/2	2 3/4	3 1/2	4 1/4	J-1	1 3/4	2	2 1/2	3 1/4
J-10	7/8	1 3/8	1 5/16	1 3/4	J-10	1 3/16	1 3/16	1	1



MOUNTINGS FOR MINIMUM OVERHANG**AMERICAN STANDARD
MOUNTING****MEDIUM DUTY**

Mounting No.	Chuck No.	Chuck Size	Spindle Size
A-314	1306	6"	5"
A-328	1308	8"	6"
A-328	1310	10"	6"
A-329	1310	10"	8"
A-330	1312	12"	6"
A-331	1312	12"	8"

LIGHT DUTY

A-324	1164	6"	4"
A-325	1284	8"	5"
A-325	1104	10"	5"
A-326	1104	10"	6"

**CAMLOCK
MOUNTING****MEDIUM DUTY**

Mounting No.	Chuck No.	Chuck Size	Spindle Size
C-240	1306	6"	3"
C-225	1306	6"	4"
C-241	1308	8"	6"
C-241	1310	10"	6"
C-242	1310	10"	8"
C-243	1312	12"	6"
C-244	1312	12"	8"

LIGHT DUTY

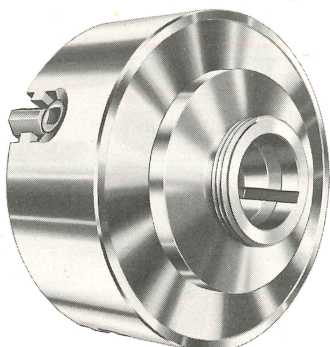
C-245	1144	4"	3"
C-245	1164	6"	3"
C-246	1284	8"	4"
C-246	1104	10"	4"

MEDIUM DUTY

Mounting No.	Chuck No.	Chuck Size	Spindle Size
L-125	1306	6"	L-00
L-139	1306	6"	L-0
L-127	1308	8"	L-00
L-136	1308	8"	L-0
L-127	1310	10"	L-00
L-136	1310	10"	L-0
L-144	1312	12"	L-0
L-145	1312	12"	L-1
L-146	1312	12"	L-2

LIGHT DUTY

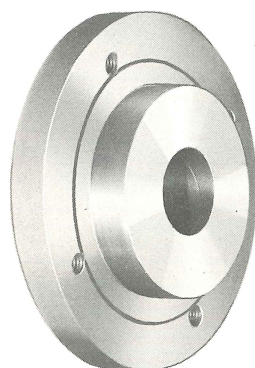
L-117	1164	6"	L-00
L-102	1284	8"	L-00
L-102	1104	10"	L-00

**LONG TAPER
MOUNTING**

Buck **INDEPENDENT** CHUCKS

THREADED MOUNTING PLATES FOR INDEPENDENT CHUCKS

REQUIRE SOME FITTING UNLESS ORDERED WITH CHUCK



Thread Size	1144	1164	Chuck Numbers		1308	1104	1310	1312
			1306	1284				
1" - 8	T-1032	T-1032	*	*	*	*	*	*
1" - 10	T-1033	T-1033	*	*	*	*	*	*
1" - 12	T-1034	T-1034	*	*	*	*	*	*
1½" - 8	T-1035	T-1035	T-1041	T-1050	*	T-1050	*	*
1¾" - 8	T-1036	T-1036	T-1042	T-1051	*	T-1051	*	*
2¼" - 8	**	T-1037	T-1043	T-1055	T-1030	T-1055	T-1030	T-1026
2⅝" - 6	**	**	T-1022	T-1058	T-1029	T-1058	T-1029	T-1025
2¾" - 8	**	**	T-1057	**	T-1028	**	T-1028	T-1024
Blank Adapter	T-1038	T-1038	T-1031	T-1059	T-1027	T-1059	T-1027	T-1023

*Chuck too large for spindle

**Spindle too large for chuck

PARTS LIST INDEPENDENT CHUCKS

CHUCK NUMBERS

MEDIUM DUTY

1306

1308

1310

1312

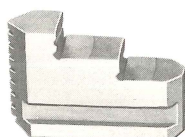
LIGHT DUTY

1144

1164

1284

1104



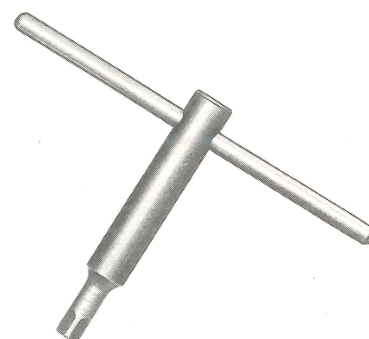
JAW



SCREW



THRUST BEARING



WRENCH

IMPORTANT

When ordering chuck parts, select part required from above and identify the number stamped on chuck face.

EXAMPLE: One (1) wrench for a No. 1312 chuck.

CHUCK BODIES MUST BE FITTED AT FACTORY

Buck

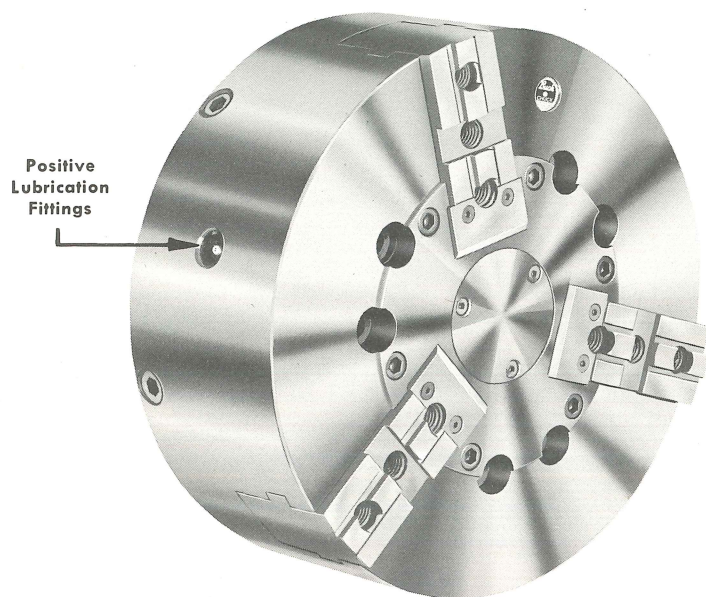
AJUST-
TRU

POWER

CHUCKS

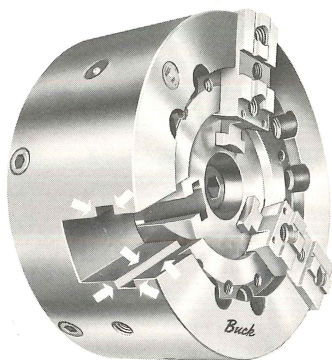
See page 18 for Aluminum Body
Gibbed Keyway Chucks

STEEL BODY



Use Patented AJUST-TRU Principle

Buck Power chucks give you so many operating "pluses" because they are built on the Buck Ajust-Tru principle. Jaws grip work like any other chuck. After the work is gripped, four or six opposed screws near the back of the chuck are used to move the chuck on its mounting plate to bring work to alignment. No further adjustment is needed to chuck duplicate parts.



Hardened Keyways Standard

Longer wear and longer accuracy, through the use of hardened keyways, is another important feature of Buck Power chucks—at no extra cost. Combined with the practicability of hardened jaws you get the ultimate in long accuracy and savings.

A whole new concept in the use of power chucks on production machines became possible with the development of the Buck Power chuck. It brought new accuracy to power chucking and a way to save many hours of down time on chucking machines. Equal pressures when gripping inside or outside diameters.

.001" Precision Guaranteed

Accuracy of .005" formerly was acceptable on such operations without special equipment. The Buck guarantees precision within .001"—with jaws gripping work under full air power—as a standard feature.

Saves hours of set-up time

The time-wasting trial and error method of fitting jaws to chucking machines is eliminated with the Buck. Now, for the first time, jaws can be machined in the tool room (with a Buck Turning Fixture, page 21) while the equipment continues production. Then the jaws can be fitted to machines and work in a matter of minutes since final precision adjustment is made by the chuck itself.

Permits hardened jaws for all operations

Since jaws no longer need be trued while in chucking position, quick-wearing soft jaws can be replaced with hardened jaws for holding rough castings or forgings for first operations, or the more critical second operations. It saves retrueing soft jaws during a long run.

Jobs can be run intermittently without re-truing jaws

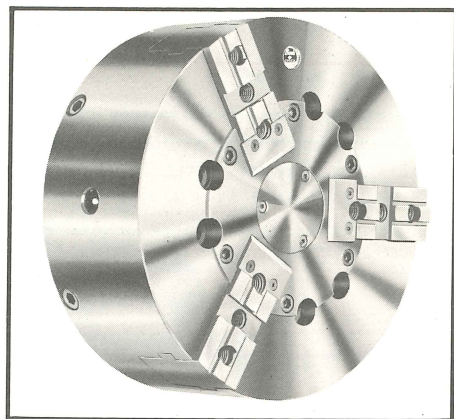
Greater flexibility in production scheduling is possible with Buck Power chucks. Since it takes but a few minutes to change jaws, and since retrueing after such a change is no longer necessary, it means that jobs can be run intermittently and interchangeably with little loss in production time.

The Buck Power chuck can be adjusted while gripping work with full air pressure—to prevent inaccuracy and save time. For safety, the Buck keeps its gripping power should an air line break exhaust the cylinder. The Buck is easily adaptable to any air or hydraulic cylinder. See page 21 for Jaw Turning fixture, and pages 22 and 23 for power accessories.

COMPENSATING CHUCKS quoted for special needs. Can be used as standard chucks by removing compensating assembly.

SPECIAL TOP JAWS OR CHUCKS — See note at bottom of page 20.

Buck ADJUST-TRU POWER CHUCKS

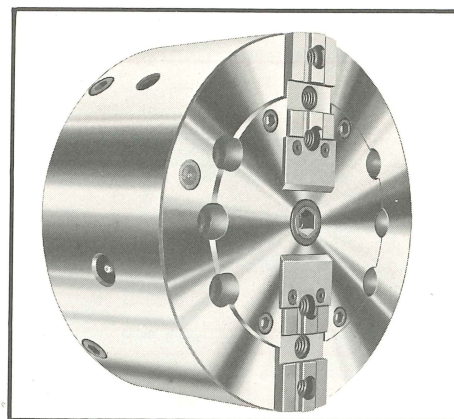


3-JAW

AMERICAN STANDARD MOUNTING



CAMLOCK and LONG TAPER MOUNTINGS available



2-JAW

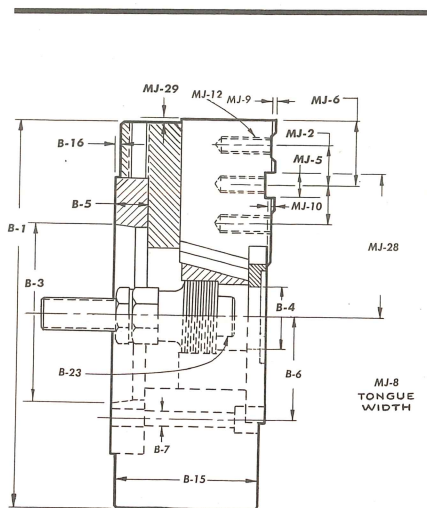
Refer to the previous page for performance features of Buck Power chucks. Below are the specifications and dimensions of chucks designed for production machines requiring American Standard mounting plates.

Buck 2-Jaw Power chucks furnish all the operating advantages of 3-jaw chucks, including guaranteed precision within .001". These chucks provide an ideal way to hold irregularly shaped pieces.

Chuck Number	Chuck Diameter	Spindle Weight	Chuck Number	Chuck Diameter	Spindle Weight
106-A5	6½"	26	126-A5	6½"	26
108-A5	8¼"	55	128-A5	8¼"	55
108-A6	8¼"	54	128-A6	8¼"	54
110-A6	10"	92	130-A6	10"	92
110-A8	10"	89	130-A8	10"	89
112-A6	12"	133	132-A6	12"	133
112-A8	12"	129	132-A8	12"	129

SEE PAGE 20 FOR TOP JAWS

PRINCIPAL DIMENSIONS



		B-1	B-3	B-4	B-5	B-6	B-7	B-15	B-16	B-23	MJ-2
6½"	106-A5										
	126-A5	6½	3.250	1.000/1.001	1½	2½	1½/32	3½	1½	5/8-18	1½
8¼"	108-A5										
	128-A5	8¼	3.250	1.500/1.501	1½	*2½	*15/32	4½	1½	5/8-18	1¾
8¼"	108-A6										
	128-A6	8¼	4.188	1.500/1.501	1½	2½	17/32	4½	1½	5/8-18	1¾
10"	110-A6										
	130-A6	10	4.188	2.000/2.001	1¼	*2½	*17/32	4½	1½	1-14	2½
10"	110-A8										
	130-A8	10	5.5007	2.000/2.001	1½	3½	21/32	4½	1½	1-14	2½
12"	112-A6										
	132-A6	12	4.188	2.000/2.001	1¼	2½	17/32	4½	1½	1-14	2½
12"	112-A8										
	132-A8	12	5.5007	2.000/2.001	1½	3½	21/32	4½	1½	1-14	2½

		MJ-5	MJ-6	MJ-8	MJ-9	MJ-10	MJ-12	MJ-28	MJ-29
6½"	106-A5								
	126-A5	.499/.500	1¾	.3105/.3125	½	¾	7/16-14	Open 2½	Close 2½
8¼"	108-A5								
	128-A5	.499/.500	17/16	.3105/.3125	½	¾	½-13	3½	2¾
8¼"	108-A6								
	128-A6	.499/.500	17/16	.3105/.3125	½	¾	½-13	3½	2¾
10"	110-A6								
	130-A6	.749/.750	11½	.498 /.500	½	¾	5/8-11	313/16	37/16
10"	110-A8								
	130-A8	.749/.750	11½	.498 /.500	½	¾	5/8-11	313/16	37/16
12"	112-A6								
	132-A6	.749/.750	2	.498 /.500	½	¾	5/8-11	4½	4½
12"	112-A8								
	132-A8	.749/.750	2	.498 /.500	½	¾	5/8-11	4½	4½

*In Mounting Plate

SPECIAL TOP JAWS OR CHUCKS — See note at bottom of page 20.

SERRATED JAW CHUCKS

AMERICAN STANDARD MOUNTING

CAMLOCK and LONG TAPER MOUNTINGS AVAILABLE

Positive Lubrication Fittings



3-JAW

(2-JAW AVAILABLE ON REQUEST)
AMERICAN STANDARD SERRATIONS

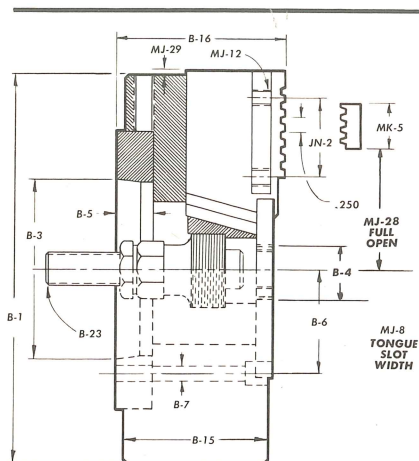
Chuck Number	Chuck Diameter	Av. Spindle Shipping Wt.
140-A6	10"	92 lbs.
140-A8	10"	89 lbs.
142-A6	12"	133 lbs.
142-A8	12"	129 lbs.

FOR TOP JAWS SEE PAGE 20

You get the greatest possible flexibility in chuck capacity with Buck Serrated Jaw chucks. Precision within .001" is guaranteed. Master keys on jaws permit moving jaws in or out 1/8" or 1/4" at a time. The Buck Ajust-Tru principle is used for final adjustment on the machine under full gripping pressure.

This same principle permits jaws to be machined in the tool room on the recommended Buck Jaw Turning Fixture (Page 21). Hardened jaws can be used for all operations. Jobs can be run intermittently without need to re-true jaws for each set-up. The chuck works equally well gripping on either outside or inside diameter. For a complete description of Buck Power chuck features see page 15.

PRINCIPAL DIMENSIONS



	B-1	B-3	B-5	B-6	B-7	B-15	B-16	B-23	MJ-8	MJ-12	MJ-28 Min.	MJ-28 Max.	MJ-29	JN-2	MK-5
10" 140-A6	10"	4.188	.625	*25/8	*17/32	49/16	53/8	1-14	.750	1/2-13	223/32	323/32	1/8	13/4	1.030
10" 140-A8	10"	5.5007	.6875	33/8	21/32	49/16	53/32	1-14	.750	1/2-13	223/32	323/32	1/8	13/4	1.030
12" 142-A6	12"	4.188	.625	*25/8	*17/32	49/16	53/8	1-14	.875	5/8-11	311/32	415/32	1/8	2	1.030
12" 142-A8	12"	5.5007	.6875	33/8	21/32	49/16	53/32	1-14	.875	5/8-11	311/32	415/32	1/8	2	1.030

B-4 Dimensions same as on Page 16.
(Jaw travel for 10" and 12" chucks is 3/8").

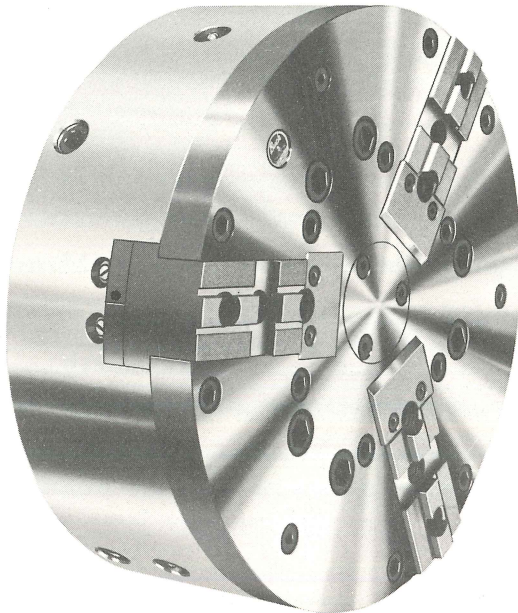
*In Mounting Plate

SPECIAL TOP JAWS OR CHUCKS — See note at bottom of page 20.

Buck AJUST-TRU® Gibbed Keyway

TONGUE and CROSS KEY

*American Standard Mounting



Simple, sound, practical—is the best way to describe this new gibbed keyway chuck development. It is made with the famous Buck Ajust-Tru principle and so guarantees precision within .001".

Gibs Take Up Wear

Two locking gibs under each jaw (see photograph) working on tapered body slots, can be tightened quickly to preserve original accuracy and eliminate the wear that develops "bell-mouthing". These, plus other long wear features, should *triple* the useful *precision life* of the chuck.

40% Weight Saving

The mid-section of aluminum and new design steel jaws reduce overall chuck weight by 40%. Starts are easier, stops quicker—reduce brake wear and machine maintenance. 40% lighter master jaws have less centrifugal effect—grip better at high speeds—make the chuck ideal for the higher spindle speeds needed to take advantage of high speed cutting tools.

(continued on next page)

3-JAW

Chuck No.	Dia.	Spindle Weight
166-A5	6½"	18
168-A5	8½"	31
169-A5	8½"	31
170-A6	10"	58
170-A8	10"	54
172-A6	12"	83
172-A8	12"	79
175-A11	15"	137
178-A11	18"	191

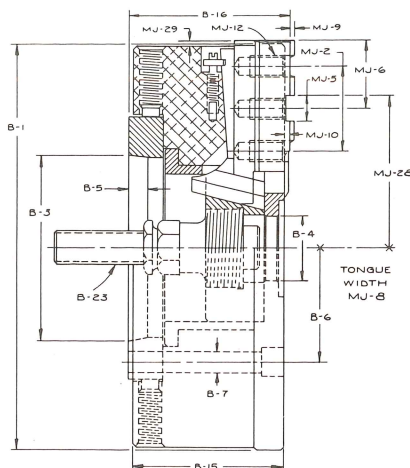
***CAMLOCK and LONG
TAPER MOUNTINGS
AVAILABLE**

TOP JAWS on page 20

2-JAW

Chuck No.	Dia.	Spindle Weight
167-A5	6½"	18
169-A5	8½"	30
169-A6	8½"	30
171-A6	10"	55
171-A8	10"	51
173-A6	12"	79
173-A8	12"	75
177-A11	15"	130
179-A11	18"	180

PRINCIPAL DIMENSIONS



		B-1	B-3	B-4	B-5	B-6	B-7	B-15	B-16	B-23	MJ-2
6½"	166-A5	6½	3.250	1.000	.5625	2½	1½	3¼	3½	5⁄8"-18	1½
	167-A5			1.001							
8½"	168-A5	8½	3.250	1.500	.5625	2½	1½	3¼	3½	5⁄8"-18	1¾
	169-A5			1.501							
8½"	168-A6	8½	4.188	1.500	.625	2½	1½	3¼	3½	5⁄8"-18	1¾
	169-A6			1.501							
10"	170-A6	10	4.188	2.000	.625	2½	1½	4¼	4½	1"-14	2½
	171-A6			2.001							
10"	170-A8	10	5.5007	2.000	.6875	3½	2½	4¼	4½	1"-14	2½
	171-A8			2.001							
12"	172-A6	12	4.188	2.000	.625	2½	1½	4¼	4½	1"-14	2½
	173-A6			2.001							
12"	172-A8	12	5.5007	2.001	.6875	3½	2½	4¼	4½	1"-14	2½
	173-A8			2.001							
15"	175-A11	15	7.750	3.187	.750	4½	2½	5½	5¾	1"-14	3
	177-A11			3.188							
18"	178-A11	18	7.750	3.187	.750	4½	2½	5½	5¾	1"-14	4½
	179-A11			3.188							

		MJ-5	MJ-6	MJ-8	MJ-9	MJ-10	MJ-12	MJ-Open	28 Close	MJ-29
6½"	166-A5	.499	1¾	.3105	⅞	¾	7⁄16"-14	2½	2½	⅞
	167-A5	.500		.3125						
8½"	168-A5	.499	1¾	.3105	⅞	¾	½"-13	3¼	2¾	⅞
	169-A5	.500		.3125						
8½"	168-A6	.499	1¾	.3105	⅞	¾	½"-13	3¼	2¾	⅞
	169-A6	.500		.3125						
10"	170-A6	.749	1⅞	.498	⅞	¾	5⁄8"-11	3¼	3¼	1⅞
	171-A6	.750		.500						
10"	170-A8	.749	1⅞	.498	⅞	¾	5⁄8"-11	3¼	3¼	1⅞
	171-A8	.750		.500						
12"	172-A6	.749	2	.498	⅞	¾	5⁄8"-11	4½	4½	⅞
	173-A6	.750		.500						
12"	172-A8	.749	2	.498	⅞	¾	5⁄8"-11	4½	4½	⅞
	173-A8	.750		.500						
15"	175-A11	.749	2½	.499	⅞	¾	¾"-10	5½	5¼	⅞
	177-A11	.750		.500						
18"	178-A11	.749	2½	.499	⅞	¾	¾"-10	5½	5¼	⅞
	179-A11	.750		.500						

"T" slots standard on all 15" and 18" chucks. Optional extra on 10" and 12" chucks.

POWER CHUCK with Aluminum Body

SERRATED

*American Standard Mounting

Steel Front Plate and Mounting

The aluminum body in no way reduces the strength of the chuck due to the design of steel front and mounting plates. The one-piece hardened front plate eliminates the distortion that sometimes develops in conventional chucks. It can be reground in your own shop.

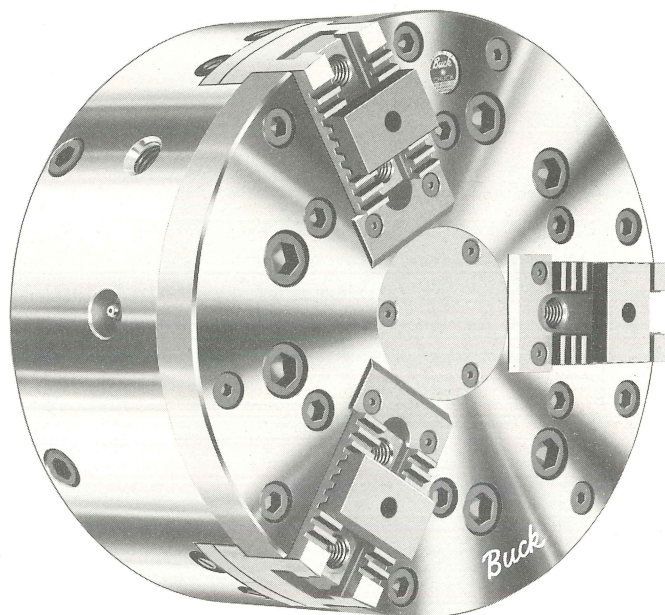
Working Surfaces Hardened, Ground, Lubricated

Front plate, master jaws, gibs, wedge are all hardened and ground. The wedge rides on a hardened and ground replaceable bushing. Grease ducts completely lubricate jaws, keyways, and wedge.

Production Advantages

To get the maximum production advantages of this chuck it should be teamed with the Buck Jaw Turning Fixture (Page 21). This enables you to *turn jaws in the tool room*. Then final precision adjustment is made on the machine under full gripping pressure using the Buck Ajust-Tru principle. Hardened jaws can be used for all operations. Intermitent runs can be made without retrueing jaws.

***CAMLOCK and LONG TAPER MOUNTINGS AVAILABLE**
TOP JAWS on page 20



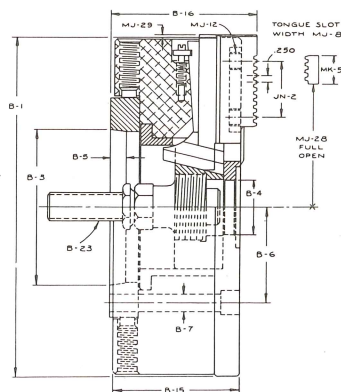
3 JAW

(2-JAW AVAILABLE ON SPECIAL ORDER)

NOTE THESE SPECIFICATIONS
10" chucks have Am. Std. Serrations only.
12" and 15" chucks have Am. Std. Serrations but are available with Square Serrations on special order.
18" chucks have Square Serrations only.

Chuck No.	Dia.	Spindle Weight
180-A6	10"	58
180-A8	10"	54
182-A6	12"	83
182-A8	12"	79
185-A11	15"	137
188-A11	18"	191

PRINCIPAL DIMENSIONS



	B-1	B-3	B-4	B-5	B-6	B-7	B-15	B-16	B-23	MJ-8	MJ-12	MJ-28		MJ-29	JN-2	MK-5
												Min.	Max.			
10" 180-A6	10"	4.188	2.000 2.001	.625	2%	1 1/32	4 7/16	4 3/4	1"-14	.750	1/2"-13	2 3/32	3 3/32	1/16	1 3/4	1.030
10" 180-A8	10"	5.5007	2.000 2.001	.6875	3%	2 1/32	4 7/16	4 3/4	1"-14	.750	1/2"-13	2 3/32	3 3/32	1/16	1 3/4	1.030
12" 182-A6	12"	4.188	2.000 2.001	.625	2%	1 1/32	4 7/16	4 3/4	1"-14	.875	1/2"-13	3 1/32	4 1/32	1/8	1 3/4	1.030
12" 182-A8	12"	5.5007	2.000 2.001	.6875	3%	2 1/32	4 7/16	4 3/4	1"-14	.875	1/2"-13	3 1/32	4 1/32	1/8	1 3/4	1.030
15" 185-A11	15"	7.750	3.187 3.188	.750	4%	2 5/32	5 3/32	5 9/16	1"-14	1.000	3/4"-10	4 1/4	5 1/8	1/8	2	1.530
18" 188-A11	18"	7.750	3.187 3.188	.750	4%	2 5/32	5 3/32	5 9/16	1"-14	1.000	3/4"-10	4 1/4	6 5/16	1/8	3 1/2	1.487

(Jaw travel for 10", 12", 15" and 18" chucks is 3/8").

SPECIAL TOP JAWS OR CHUCKS — See note at bottom of page 20.

Buck

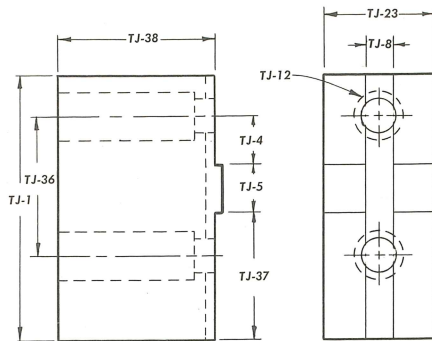
ADJUST-TRU

POWER

CHUCKS

TOP JAWS

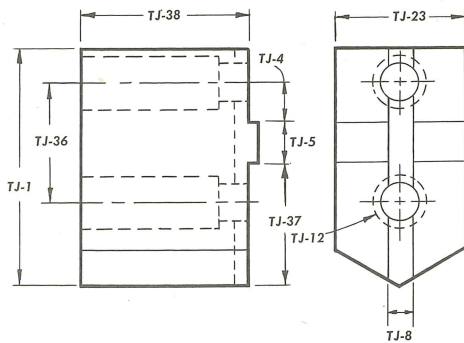
For BUCK Power Chucks and all other chucks with AMERICAN STANDARD Master Jaws



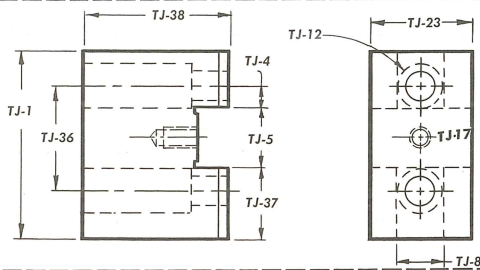
STANDARD TOP JAWS

	6 1/2" Diam.	8 1/4" Diam.	10" Diam.	12" Diam.	15" Diam.	18" Diam.
TJ-1	2 7/16	3	3 3/4	4 3/4	6	6
TJ-4	1/2	5/8	1 1/16	7/8	1 1/8	1 1/8
TJ-5	.499	.499	.749	.749	.749	.749
TJ-8	.3135	.3135	.501	.501	.501	.501
TJ-12	1 5/32	1 1/32	2 1/32	2 1/32	2 5/32	2 5/32
TJ-23	1 5/8	1 5/8	2	2	2 1/2	2 1/2
TJ-36	1 1/2	1 3/4	2 1/8	2 1/2	3	3
TJ-37	1	1 5/16	1 11/16	2 3/8	3 3/16	3 3/16
TJ-38	2	2	2 7/8	2 7/8	3 1/4	3 1/4
Order Nos.	TJ-106	TJ-108	TJ-110	TJ-112	TJ-175	TJ-178
Based on Chuck Nos.	TJ-126	TJ-128	TJ-130	TJ-132	TJ-177	TJ-179
	TJ-166	TJ-168	TJ-170	TJ-172		
	TJ-167	TJ-169	TJ-171	TJ-173		

POINTED SOFT TOP JAWS

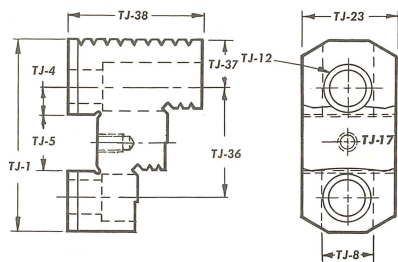


	6 1/2" Diam.	8 1/4" Diam.	10" Diam.	12" Diam.	15" Diam.	18" Diam.
	Std. X-High	Std. X-High	Std. X-High	Std. X-High	Std. X-High	Std. X-High
TJ-1	3 1/16	3 1/16	3 7/8	4 11/16	5 11/16	7 1/8
TJ-4	1/2	1/2	5/8	1 1/16	7/8	1 1/8
TJ-5	.499	.499	.499	.749	.749	.749
TJ-8	.3135	.3135	.3135	.501	.501	.501
TJ-12	1 5/32	1 5/32	1 5/32	2 1/32	2 1/32	2 5/32
TJ-23	1 5/8	1 5/8	1 5/8	2	2	2 1/2
TJ-36	1 1/2	1 1/2	1 3/4	2 1/8	2 1/2	3
TJ-37	1 5/8	1 5/8	2 3/8	2 3/8	3 3/8	4 7/16
TJ-38	2	2 7/8	2	2 7/8	4 7/8	5 7/8
ORDER NOS.	PTJ 106	HPTJ 108	PTJ 110	HPTJ 112	PTJ 175	HPTJ 178
Based on Chuck Nos.	PTJ 126	HPTJ 128	PTJ 130	HPTJ 132	PTJ 177	HPTJ 179
	PTJ 167	HPTJ 169	PTJ 171	HPTJ 173		



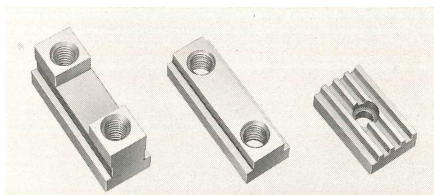
SERRATED SOFT BLANK TOP JAWS

Order Nos.	TJ-1	TJ-4	TJ-5	TJ-8	TJ-12	TJ-17	TJ-23	TJ-36	TJ-37	TJ-38
10" TJ-140 & 180	3 3/16	2 3/4	1.031	.749	1 7/32	5/16-18	1 3/4	1 3/4	1 3/8	2 1/2
12" TJ-142 & 182	4 1/8	3 1/4	1.031	.874	2 1/32	5/16-18	1 3/4	2	1 7/8	2 1/2
15" TJ-185	6	3 1/4	1.530	.997	2 5/32	3/8-16	2 1/2	2 1/2	2 3/16	3 1/4
18" TJ-188	6	1/2	1.488	1.002	2 5/32	3/8-16	2 1/2	2 1/2	3 1/4	3 1/4



HARD REVERSIBLE STEPPED TOP JAWS

ORDER NOS.	PART DIAMETERS MIN.	PART DIAMETERS MAX.	TJ-1	TJ-4	TJ-5	TJ-8	TJ-12	TJ-17	TJ-23	TJ-36	TJ-37	TJ-38
10" ST-140 & 180	2 1/2	9 1/2	3	2 3/4	1.031	.749	1 7/32	5/16-18	1 3/4	1 3/4	1 3/8	2 1/2
12" ST-142 & 182	3 1/2	11	3 1/2	3 1/4	1.031	.874	2 1/32	5/16-18	1 3/4	2	1 7/8	2 1/2
15" ST-185	4 5/8	14	4 3/4	3 1/4	1.531	.997	2 5/32	3/8-16	2 1/2	2 1/2	2 3/16	3 1/4
18" ST-188	4 3/8	17	4 3/4	1/2	1.488	1.002	2 5/32	3/8-16	2 1/2	2 1/2	1 1/4	4



JAW NUTS

MASTER KEY

JAW NUTS and MASTER KEY

	Am. Std. Serrations	Square Serrations	10"	12"	15"	18"
MASTER KEY (Order No.)	10386	10386	11079	11445	11449	11449
Jaw Nuts (Order No.)	10390	10387	11080	11446	11450	11450

SPECIAL TOP JAWS or CHUCKS FOR SPECIAL PARTS

An important part of Buck service includes (1) supplying top jaws machined to size for holding special parts and (2) designing and building complete chucks for holding special parts. In writing for information include print of piece to be held and data about production machine.

JAW TURNING FIXTURES

End production downtime for jaw turning

These Buck-designed Jaw Turning Fixtures—for American Standard Tongue and Cross Key, or Serrated Master Jaw types—work as a team with Buck Power chucks to end the downtime costs formerly required to turn jaws on production equipment.

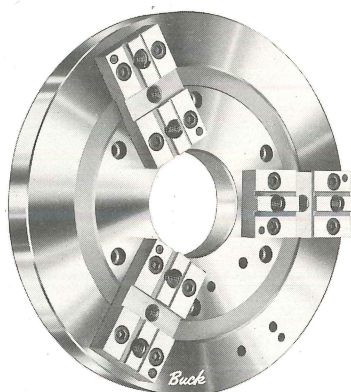
The Fixture Jaw Bases duplicate those of the chuck Master Jaws. They hold top jaws for machining, or grinding after hardening, *in the tool room*. Final precision adjustment is made on chucking machines *under full air pressure* using the Buck Adjust-Tru principle. Precision within .001" is guaranteed.

These Fixtures can be used to turn jaws for any of the Buck Adjust-Tru Power chucks. And since

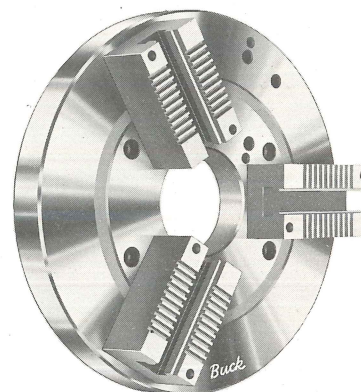
final adjustment is possible, it makes hardened jaws practical for *all* operations. It also permits you to run jobs intermittently without need for retooling jaws when they are put back on the machines.

Recommended practice in using the fixtures is to assign one lathe in the tool room for top jaw turning. You can then select a standard Buck mounting plate designed to fit both lathe spindle and Fixture.

The Fixture is not recommended for finish sizing on "wrap around" top jaw types. While the Adjust-Tru feature compensates for transfer errors from Fixture to chuck, the final sizing for such jaws should be done with them in position on the chuck.



**Fixtures
can be used
to turn jaws
for both steel
and aluminum
body power chucks**



TONGUE and CROSS KEY

Groove in Fixture base gives location of master jaws in mid-travel position. Jaw bases are reversible for O.D. or I.D., which allows top jaws to be contoured $\frac{1}{16}$ " in or $\frac{1}{16}$ " out from mid-travel position.

Chuck Size	Fixture Number	Mounting Plates (See Page 7)	
5 5/8"	1049B	Special—write	
6-6 1/2"	1049	Special—write	
8 1/4"	1050	Standard 6"	Ajust-Tru
10"	1051	Standard 7 1/2"	Ajust-Tru
12"	1052	Standard 7 1/2"	Ajust-Tru
15"	1055	Standard 9"	Ajust-Tru
18"	1058	Standard 9"	Ajust-Tru

NOTE: 18" Fixtures also turn 15" jaws.

SERRATED MASTER

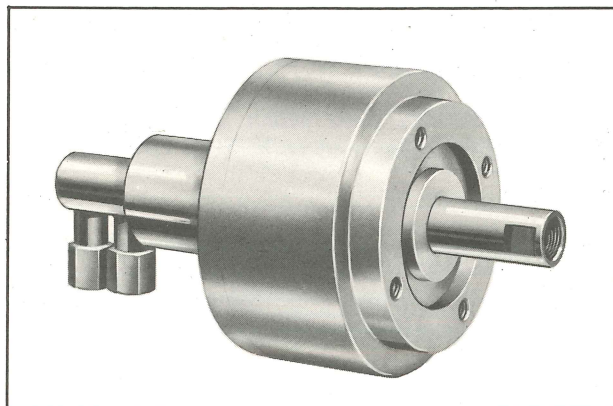
Note that both types of serrated masters are available. Chuck dimensions below are with master jaws in full open position. Master jaw travel is $\frac{3}{8}$ ". Fixture includes: master keys, jaw nuts and cap screws.

American Std. SERRATIONS	Master Position Max.	Min.	Mounting Plates Standard Ajust-Tru (See P. 7)
Chuck Diam. 10"	4 3/4	3 3/4	7 1/2"
Fixture No. 1053	4 33/64	3 41/64	
Chuck Diam. 12"	5 1/2	4 3/8	7 1/2"
Fixture No. 1054	5 21/64	4 11/64	
Chuck Diam. 15"	7	5 7/8	9"
Fixture No. 1057	6 7/8	5 3/4	
SQUARE SERRATIONS			
Chuck Diam. 12"	5 47/64	4 23/64	7 1/2"
Fixture No. 1061	5 35/64	4 11/64	
Chuck Diam. 15"	6 55/64	5 47/64	9"
Fixture No. 1060	6 43/64	5 35/64	
Chuck Diam. 18"	8 23/64	5 47/64	9"
Fixture No. 1059	8 11/64	5 35/64	

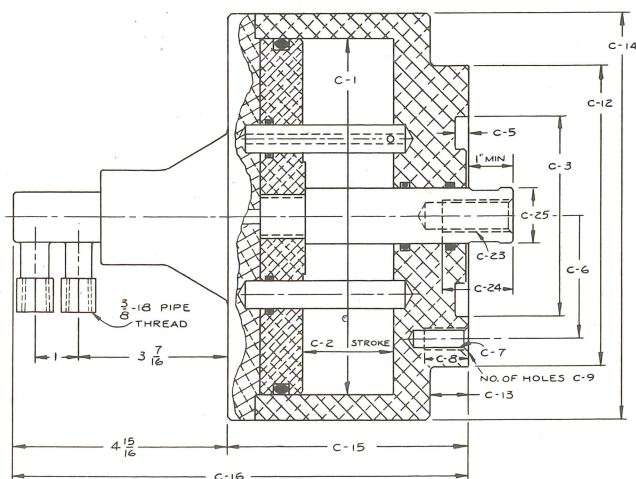
NOTE: 18" Fixtures also turn 15" jaws.

AIR CYLINDERS

HIGH SPEED

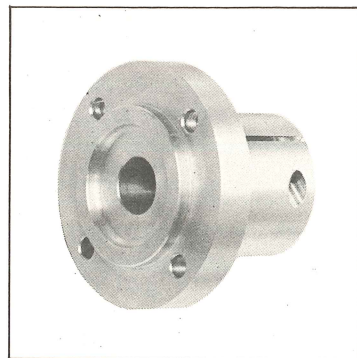


This new Buck Double Acting Aluminum Air Cylinder has design improvements with several distinct advantages on high speed production. Its simplified method of air transfer maintains full draw rod thrust while reducing both overall diameter and weight—making it approximately 25% lighter than all other aluminum cylinders. Conventional packing has been eliminated, along with maintenance, by a unique sealing construction. It is also self lubricating and self adjusting to take up wear. Its lightness, operating speed, and durability make it ideal for taking full advantage of the latest high speed machining methods.

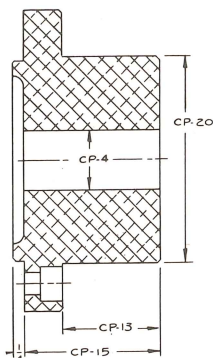


Cylinder Size & Order Number

	4 1/2"	6"	8"	10"
	No. 1604	No. 1606	No. 1608	No. 1610
C-1	4 1/2	6	8	10
C-2	1	1 1/2	2	2
C-3	3.002	4.502	4.502	6.002
	3.000	4.500	4.500	6.000
C-5	5/16	5/16	5/16	5/16
C-6	1 7/8	2 3/4	2 3/4	3 1/2
C-7	3/8-16	1/2-13	1/2-13	5/8-11
C-8	3/8	7/8	1	1
C-9	4	4	4	6
C-12	4 3/4	6 3/4	6 3/4	8 3/8
C-13	5/8	1 1/8	7/8	1
C-14	5 1/2	7	9 1/8	11 1/4
C-15	3 1/2	4 1/8	5 13/32	5 7/8
C-16	8 7/16	9 1/2	10 11/32	10 13/16
C-23	3/4-16	3/4-16	3/4-16	1-14
C-24	1 3/8	1 3/8	1 3/8	1 1/2
C-25	1	1 1/4	1 1/4	1 1/2



Finished Adapter shown



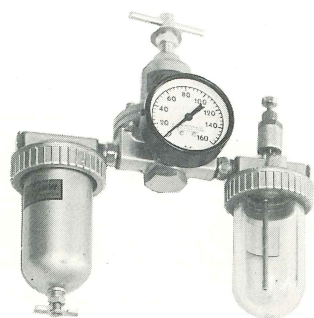
Semi-Finished ADAPTERS

Cylinder Size & Order Number

	4 1/2"	6"	8"	10"
	No. 1004	No. 1006	No. 1006	No. 1010
CP-4	1 1/8	1 3/8	1 3/8	1 3/4
CP-13	2 3/8	2 1/4	2 1/4	2 1/4
CP-15	3 1/8	3 1/8	3 1/8	3 13/32
CP-20	3 1/8	4 3/8	4 3/8	6

See price list for cost of fitting adapters

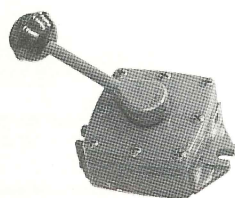
AIR ACCESSORIES



COMPLETE AIR UNIT

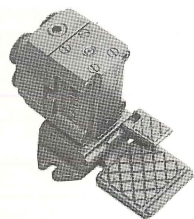
Includes FILTER, LUBRICATOR, REGULATING VALVE and GAUGE

Order No. 1044— $\frac{1}{4}$ " for $4\frac{1}{2}$ ", 6", and 8" Cylinders.
Order No. 1045— $\frac{3}{8}$ " for 10" and 12" Cylinders.



HAND OPERATED VALVES

Order No.	Pipe Size	Shipping Wt.
1046	$\frac{1}{4}$ "	5 lbs.
1047	$\frac{3}{8}$ "	5 lbs.



FOOT OPERATED VALVE

Order No.	Pipe Size	Shipping Wt.
1042	$\frac{3}{8}$ "	5 lbs.

DRAW TUBE



Variable lengths and diameters. When ordering, specify machine make, model and spindle nose type.

DRAW BAR



Order No. 1040—for power operated chucks. When ordering this part, machine make, model number, spindle nose type, and overall length of spindle must be given.

FREE CHARTS, FULL SIZE

There are probably several men and places in your plant where this Nomograph can be useful. If so, ask for the copies you need and they will be sent promptly. Referring to the Nomograph on every job is a good way to reduce air waste and its cost, to develop a reliable guide for reducing distortion on tube machining, and to increase chuck and jaw life by reducing the wear caused by unnecessarily high pressure operation.

Buck ADJUST-TRU POWER CHUCKS

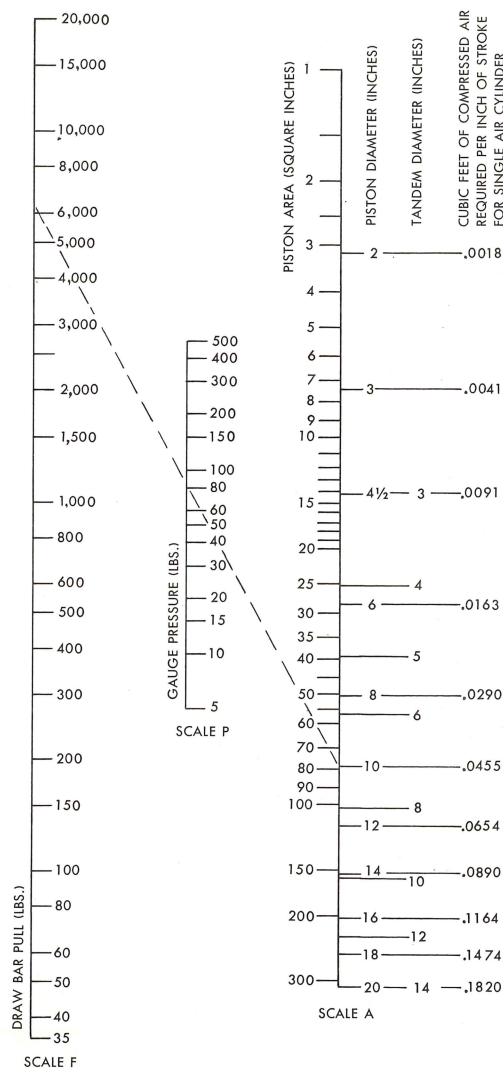
Buck Power Chucking Nomograph

The Nomograph below provides a quick way to calculate air cylinder and draw rod requirements. It is useful in two ways: (1) For selecting the correct equipment and pressures for the draw bar pull desired and, just as important, (2) To check on pressures and pull developed with existing equipment to make sure that safe limits are not being exceeded. For duplicate copies see offer below.

NOMOGRAPHIC CHART FORCE = PRESSURE \times PISTON AREA

DRAW ROD DIA.	$\frac{3}{4}$	1	$1\frac{1}{4}$	$1\frac{1}{2}$
AREA	.442	.785	1.227	1.776

To compute cylinder draw rod pull: deduct area of draw rod from piston area. Plot on "A" scale and proceed as shown in example.



Knowing any two of the variables in the equation $F = P \times A$, find the third by applying a straight edge through known figures on respective scales and read answer at third scale intersection.

Example:
10" dia. cylinder operating at 80 psi gives 6300 lbs. draw rod thrust and uses .0455 cubic feet of compressed air per inch of stroke.

NEW Buck "Quick-Set" CHUCK

Adjusts by 16ths . . . saves 85% set-up time . . .
saves reboring top jaws001" precision

The Buck engineering staff has "done it again" with this revolutionary chucking development that ends time wasting serrated chuck operations.

The picture at the left tells the story. Unique adjustable jaws, indexed by *sound or feel* for $\frac{1}{16}$ " diameter changes ($\frac{1}{32}$ " per jaw), eliminate master keys and the time it takes to remove and replace the 6 cap screws on conventional serrated jaw chucks. The new "Quick-Set" takes all standard serrated top jaws — no need to get new ones — as well as Buck hardened step jaws.

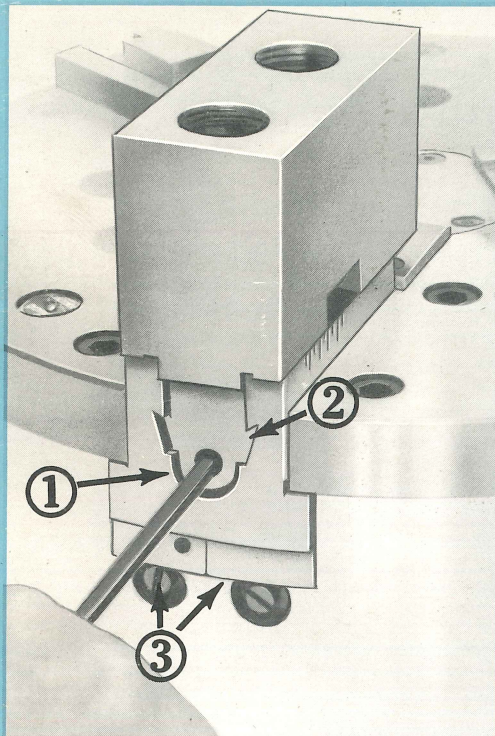
Shortening the adjustable increment to $\frac{1}{16}$ " saves most reboring of top jaws.

Final precision within .001" is guaranteed by the patented Buck Ajust-Tru principle. The new 1-piece master jaw design assures more rigidity, less inaccuracy. Plates shield chuck interior from chips.

Note also the unique new 20° V-slots in the jaw nut to end the problem of expansion and contraction of master jaws. It firmly locks top jaws, reduces chucking errors. Aluminum body chucks have gibs under jaws to take up wear, prevent "bell-mouthing", prolong accuracy.

Diameter capacity changes are: 10" - 2", 12" - 2 $\frac{1}{4}$ ", 15" - 2 $\frac{1}{4}$ ", 18" - 5 $\frac{1}{4}$ ". Ask for literature.

(Conventional Serrated Jaw Chucks shown on pages 17 and 19).



This jaw photo highpoints advantages over old-style serrated chucks.

(1) Adjustable master jaws are positioned by simply moving an interior screw in or out. It indexes by *sound or feel* for $\frac{1}{16}$ " diameter changes ($\frac{1}{32}$ " per jaw). There are also indexing marks on side of master jaw.

(2) New V-slot construction successfully prevents expansion or contraction of master jaws for improved accuracy and much less wear.

(3) Gibs under jaws on aluminum body chucks take up wear, prevent bell-mouthing, greatly prolong chuck operating accuracy.

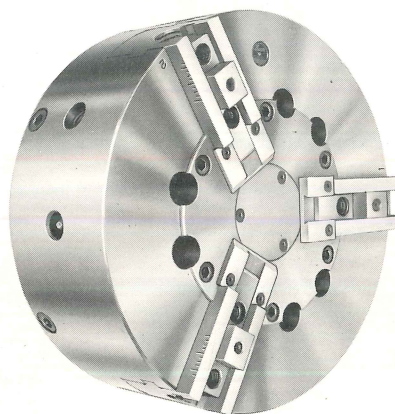
(These 3 features are patented or have patents pending.)

SPECIAL JAW TURNING FIXTURES

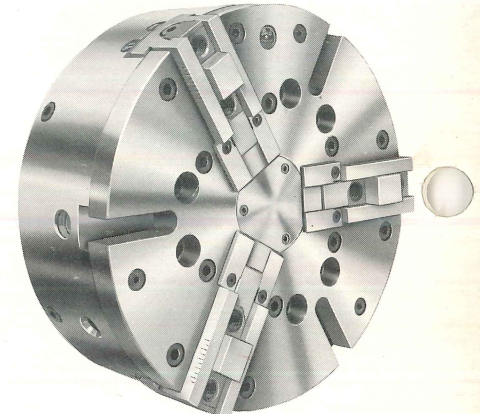
Refer to page 21 for Jaw Turning Fixtures — the most practical yet developed.

For special fixtures, or help on any top jaw forming problems, write the factory or contact your nearest Buck District Manager.

ALL STEEL*



ALUMINUM BODY*



CHUCK NUMBERS Top Jaw Type Am. Serrated	CHUCK DIAM.	APPROX. WT.
--	----------------	----------------

3-JAW CHUCKS

1910	10"	90
1912	12"	131

2-JAW CHUCKS

3510	10"	90
3512	12"	131

CHUCK NUMBERS Top Jaw Type Am. Serr. Sq. Serr.	CHUCK DIAM.	APPROX. WT.
--	----------------	----------------

3-JAW CHUCKS

2310	—	10"	56
2312	—	12"	81
2315	2715	15"	137
—	2718	18"	191

2-JAW CHUCKS AVAILABLE

*AMERICAN STANDARD MOUNTING
Camlock and Long Taper Mountings Available

DISTRICT MANAGERS

WENDELL ANDERSON
1 Alan
Nashua, New Hampshire

BERNARD BURWELL
10508 Greer Drive, Route 1
Richland, Michigan

JOHN DEMING
528 Fairview
Kalamazoo, Michigan

HENRY DUTTON
7426 Angling Road
Kalamazoo, Michigan

WALTER TOUCHTON
2919 Denise Road
Norristown, Penna.

JAMES VERONA
638 Duff Avenue
La Puente, California

JACK W. WOODARD
11239 Alvin Street
Dallas 18, Texas

BUCK TOOL COMPANY

7025 East Michigan Avenue, Route 3
Kalamazoo, Michigan 49001

935-5700

Buck Chucks

IMPORTANT: All prices are subject to change without notice and those in effect at date of shipment will apply. All prices are F.O.B. factory, Kalamazoo, Michigan, U.S.A. We reserve the right to make changes in design and specifications without notice.

AJUST-TRU SELF-CENTERING SCROLL CHUCKS

CATALOG PAGE 4

Three jaw scroll chucks with one set of external and one set of internal jaws, including wrench.

CHUCK NO.	CHUCK DIAMETER	PRICE
1434	4"	\$ 94.00
2534	5"	115.00
3634	6"	147.00
4733	7½"	197.00
4831	8¼"	225.00
5933	9"	249.00
5103	10"	310.00
5124	12"	350.00

Six-jaw scroll chucks with one set of external and one set of internal jaws, including wrench.

CHUCK NO.	CHUCK DIAMETER	PRICE
1462	4"	\$ 122.00
2562	5"	148.00
3662	6"	189.00
4761	7½"	249.00
4862	8¼"	288.00
5961	9"	333.00
5106	10"	430.00
5127	12"	498.00

Chucks with only one set of jaws are priced the same as chucks with master jaws only. (See page 5.)

CATALOG PAGE 5

Three-jaw scroll chucks with master and hardened reversible stepped top jaws, including wrench.

CHUCK NO.	CHUCK DIAMETER	PRICE
2063R	6"	\$ 147.00
2073R	7½"	197.00
2083R	8¼"	225.00
2093R	9"	249.00
2103R	10"	310.00
2124R	12"	350.00
2153R	15"	490.00
2183R	18"	850.00
2213R†	21"	1,290.00
2243R†	24"	1,730.00

Three, six, and two-jaw scroll chucks with master jaws only, including wrench.

THREE-JAW CHUCKS

CHUCK NO.	CHUCK DIAMETER	PRICE
2063	6"	\$ 126.00
2073	7½"	155.00
2083	8¼"	200.00
2093	9"	220.00
2103	10"	275.00
2124	12"	304.00
2153	15"	427.00
2183	18"	770.00
2213†	21"	998.00
2243†	24"	1,450.00

†Shown in Catalog 66. To be available Spring, 1967.

SIX-JAW CHUCKS

CHUCK NO.	CHUCK DIAMETER	PRICE
2066	6"	\$ 165.00
2076	7½"	213.00
2086	8¼"	249.00
2096	9"	294.00
2106	10"	375.00
2127	12"	415.00
2156	15"	650.00
2186	18"	998.00

TWO-JAW CHUCKS

CHUCK NO.	CHUCK DIAMETER	PRICE
3623	6"	\$ 126.00
4822	8¼"	200.00

CATALOG PAGE 6

Mounting plates will fit all chucks of the same diameter. For Ajust-Tru scroll chucks only.

AMERICAN STANDARD FLANGED NOSE TYPES A-1 AND A-2

MOUNTING PLATE NO.	CHUCK DIAM.	SPINDLE NOSE SIZE	PRICE
A-300	6"	A3	\$ 40.00
A-301	6"	A4	40.00
A-302	6"	A5	40.00
A-350	7½"	A3	46.00
A-351	7½"	A4	46.00
A-352	7½"	A5	46.00
A-353	7½"	A6	59.00
A-306	8¼"	A4	56.00
A-307	8¼"	A5	56.00
A-308	8¼"	A6	59.00
A-361	9"	A4	56.00
A-362	9"	A5	63.00
A-363	9"	A6	68.00
A-312	10"	A6	85.00
A-313	10"	A8	102.00
A-315	12"	A6	85.00
A-316	12"	A8	105.00
A-317	12"	A11	150.00
A-344	15" or 18"	A8	105.00
A-345 For 3 Jaw	15" or 18"	A11	126.00
A-349 For 6 Jaw	15" or 18"	A11	126.00
A-386	21" or 24"	A11	190.00
A-389	21" or 24"	A15	250.00

CAMLOCK TYPE D-1

MOUNTING PLATE NO.	CHUCK DIAM.	SPINDLE NOSE SIZE	PRICE
C-203	6"	D3	\$ 46.00
C-201	6"	D4	46.00
C-202	6"	D5	46.00
C-254	7½"	D3	46.00
C-251	7½"	D4	46.00
C-252	7½"	D5	56.00
C-253	7½"	D6	56.00
C-204	8¼"	D4	56.00
C-208	8¼"	D5	56.00
C-209	8¼"	D6	56.00
C-207	8¼"	D8	99.00
C-222	9"	D4	56.00
C-262	9"	D5	56.00
C-263	9"	D6	68.00
C-264	9"	D8	99.00
C-211	10"	D6	85.00
C-212	10"	D8	99.00
C-214	12"	D6	85.00
C-215	12"	D8	105.00
C-238	15"	D6	105.00
C-267	15" or 18"	D8	105.00

LONG TAPER KEY DRIVE — TYPE L

MOUNTING PLATE NO.	CHUCK DIAM.	SPINDLE NOSE SIZE	PRICE
L-100	6"	L-00	\$ 28.00
L-101	6"	L-0	47.00
L-150	7½"	L-00	23.00
L-151	7½"	L-0	23.00
L-108	8¼"	L-00	23.00
L-109	8¼"	L-0	23.00
L-110	8¼"	L-1	54.00
L-160	9"	L-00	28.00
L-161	9"	L-0	34.00
L-162	9"	L-1	56.00
L-112	10"	L-0	39.00
L-113	10"	L-1	39.00
L-114	10"	L-2	170.00
L-115	12"	L-0	46.00
L-116	12"	L-1	66.00
L-166	12"	L-2	99.00
L-170	15" or 18"	L-0	63.00
L-171	15" or 18"	L-1	94.00
L-172	15" or 18"	L-2	131.00
L-173	15" or 18"	L-3	225.00
L-163	21" or 24"	L-2	220.00
L-169	21" or 24"	L-3	290.00

THREADED SPINDLE NOSE

MOUNTING PLATE NO.	CHUCK DIAM.	SPINDLE NOSE SIZE	PRICE
T-900	4"	1"-8	\$ 7.50
T-901	4"	1"-10	7.50
T-902	4"	1"-12	7.50
T-903	4"	1½"-8	7.50
T-904	4"	1¾"-8	7.50
T-905	4"	semi-finished	4.50
T-925	5"	1"-8	7.50
T-926	5"	1"-10	7.50
T-927	5"	1"-12	7.50
T-928	5"	1½"-8	7.50
T-929	5"	1¾"-8	7.50
T-931	5"	semi-finished	5.00
T-950	6"	1½"-8	9.50
T-951	6"	1¾"-8	9.50
T-955	6"	2¼"-8	9.50
T-958	6"	2¾"-6	9.50
T-959	6"	semi-finished	6.00
T-978	7½"	2¼"-8	19.00
T-981	7½"	2¾"-6	19.00
T-982	7½"	semi-finished	8.50
T-985	8¼"	2¼"-8	24.00
T-986	8¼"	2¾"-6	24.00
T-988	8¼"	2¾"-8	24.00
T-987	8¼"	semi-finished	10.50
T-990	9"	2¼"-8	24.00
T-991	9"	2¾"-6	24.00
T-993	9"	2¾"-8	24.00
T-992	9"	semi-finished	10.50
T-994	10"	2¼"-8	40.00
T-995	10"	2¾"-6	40.00
T-989	10"	2¾"-8	40.00
T-996	10"	semi-finished	18.00
T-997	12"	2¾"-6	50.00
T-999	12"	2¾"-8	50.00
T-998	12"	semi-finished	25.00
T-1003	15" or 18"	semi-finished	90.00
T-1000	21" or 24"	semi-finished	100.00

CATALOG PAGE 7

Self-centering scroll chucks fitted for Hardinge and Elgin 2½"-10 Threaded Type Spindle, including wrench.

CHUCK NUMBER	DIAMETER AND TYPE	PRICE
2534-H	5"-3 Jaw Univ.	\$ 146.00
2562-H	5"-6 Jaw Univ.	179.00
3634-H	6"-3 Jaw Univ.	178.00
3662-H	6"-6 Jaw Univ.	220.00
S-276	Mounting Plate only for 6" chuck	31.00

Self-centering scroll chucks fitted for Hardinge and Elgin 4° Taper Type Spindle, including wrench.

CHUCK NUMBER	DIAMETER AND TYPE	PRICE
2534-HT	5"-3 Jaw Univ.	\$ 154.00
2562-HT	5"-6 Jaw Univ.	187.00
3634-HT	6"-3 Jaw Univ.	186.00
3662-HT	6"-6 Jaw Univ.	228.00
S-357	Mounting plate only for 6" chuck	39.00

Self-centering 5" scroll chucks for 2¼"-8 Threaded Spindles, including wrench. Not shown in catalog.

CHUCK NUMBER	MOUNTING NO.	DIAMETER AND TYPE	PRICE
2534-B	S-155	5"-3 Jaw Univ.	\$ 146.00
2562-B	S-155	5"-6 Jaw Univ.	179.00

Specify chuck and mounting number on order.

Standard stock jaws available for self-centering scroll chucks. Two, three and six jaw body types.

IMPORTANT INFORMATION REQUIRED — We must be advised of the chuck number stamped on the chuck face in order to supply the proper jaws.

NOTE — Jaws are priced each — Not per set.

CHUCK DIAM.	STYLE No. 1	PRICE EACH	STYLE No. 2	PRICE EACH	STYLE No. 8	PRICE EACH	STYLE No. 9	PRICE EACH	STYLE No. 5	PRICE EACH	STYLE No. 6M	PRICE EACH	STYLE No. 3T	PRICE EACH	STYLE No. 7	PRICE EACH
4"	No. 1	\$ 4.00	No. 2	\$ 4.00	No. 8	\$ 4.00	No. 9	\$ 4.00	No. 5	\$ 3.00	*	*	*	*	*	*
5"	No. 1	5.00	No. 2	5.00	No. 8	5.00	No. 9	5.00	No. 5	4.00	*	*	*	*	*	*
6"	No. 1	8.00	No. 2	8.00	No. 8	8.00	No. 9	8.00	No. 5	6.00	No. 6M	\$ 8.00	No. 3T	\$ 8.00	No. 7	\$ 5.00
7½"	No. 1	12.00	No. 2	12.00	No. 8	12.00	No. 9	12.00	No. 5	7.00	No. 6M	10.00	No. 3T	12.00	No. 7	6.00
8¼"	No. 1	13.00	No. 2	13.00	No. 8	13.00	No. 9	13.00	No. 5	8.00	No. 6M	11.00	No. 3T	13.00	No. 7	6.00
9"	No. 1	13.00	No. 2	13.00	No. 8	13.00	No. 9	13.00	No. 5	8.00	No. 6M	11.00	No. 3T	13.00	No. 7	6.00
10"	No. 1	17.00	No. 2	17.00	No. 8	17.00	No. 9	17.00	No. 5	10.00	No. 6M	18.00	No. 3T	17.00	No. 7	8.00
12"	No. 1	21.00	No. 2	21.00	No. 8	21.00	No. 9	21.00	No. 5	14.00	No. 6M	22.00	No. 3T	21.00	No. 7	9.00
15"	*	*	*	*	*	*	*	*	*	*	No. 6M	40.00	No. 3T	40.00	No. 7	10.00
18"	*	*	*	*	*	*	*	*	*	*	No. 6M	40.00	No. 3T	40.00	No. 7	10.00
21"	*	*	*	*	*	*	*	*	*	*	No. 6M	70.00	No. 3T	80.00	No. 7	12.00
24"	*	*	*	*	*	*	*	*	*	*	No. 6M	70.00	No. 3T	80.00	No. 7	12.00

Mountings for Brown and Sharpe No. 13 Grinder, Pulley Type with 1½"-6 L.H. Threaded Spindle. For Serial 6325 and up.

MOUNTING PLATE NO.	DIAMETER AND TYPE	PRICE
S-132	4" Univ.	\$ 79.00
S-192	5" Univ.	79.00
S-131	6" Univ.	79.00
S-358	7½" Univ.	79.00
S-349	6" Ind. L.D.	79.00
S-350	8" Ind. L.D.	79.00

Mountings for No. 12 B & S and No. 5 M.T. Spindles.

MOUNTING PLATE NO.	TAPER	DIAMETER AND TYPE	PRICE
S-296	5 MT	4" Univ.	\$ 37.00
S-302	12 BS	4" Univ.	37.00
S-297	5 MT	5" Univ.	37.00
S-303	12 BS	5" Univ.	37.00
S-298	5 MT	6" Univ.	37.00
S-299	12 BS	6" Univ.	37.00
S-359	5 MT	4" Ind. L.D.	37.00
S-282	12 BS	4" Ind. L.D.	37.00
S-359	5 MT	6" Ind. L.D.	37.00
S-282	12 BS	6" Ind. L.D.	37.00

No. 11 B & S also available at No. 12 prices.

Mounting for Nos. 40 and 50 Mill Taper Spindles. Taper mounting.

MOUNTING PLATE NO.	DIAMETER AND TYPE	TAPER NO.	PRICE
S-280	6" Ind. M.D.	50	\$ 98.00
S-247	6" Univ.	40	98.00
S-246	6" Univ.	50	98.00
S-245	7½" Univ.	50	98.00
S-379	8¼" Univ.	50	98.00
S-829	8" Ind. M.D.	50	98.00
S-237	9" Univ.	50	98.00

Mounting Plates for Heald Internal Grinders. Scroll chucks.

MOUNTING PLATE NO.	DIAMETER AND TYPE	"B"-FLANGE PILOT DIAM.	"C"-BOLT CIRCLE	PRICE
S-344	6" Univ.	9⅝"	8"	\$ 79.00
S-190	9" Univ.	9⅝"	8"	79.00
S-347	9" Univ.	11"	9"	98.00
S-348	10" Univ.	11"	9"	98.00

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Dust Proof. Self-centering three-jaw Scroll Chucks with masters and hardened reversible stepped top jaws, including wrench.

CHUCK NO.	CHUCK DIAMETER	PRICE
2063DP	6"	\$ 290.00
2093DP	9"	390.00
2124DP	12"	498.00

	6"	9"	12"
Stepped Top Jaws	10658-1	10617	10839-1
Set of 3	\$68.00	\$77.00	\$104.00
Blank Soft Top Jaws	10658	10617-4	10839
Set of 3	\$20.00	\$26.00	\$33.00

PARTS LIST FOR AJUST-TRU SCROLL CHUCKS

CHUCK DIAM.	1 - FRONT 2 - BACK	SCROLL★	PINION★	PINION RETAINER	WRENCH★	PRESSURE★ PLUGS EACH	ADJUSTING SCREWS EACH	MOUNTING SCREWS (Outside Dia.) EACH	CHUCK SCREWS (Inside Dia.) EACH	GREASE FITTINGS Set of 2, 3, or 6
4 inch		\$10.50	\$ 4.20	—	\$ 2.30	\$.50	\$.50	\$.25	\$.25	\$10.00
5 inch		12.60	5.25	—	2.90	.50	.75	.25	.25	10.00
6 inch	FRONT	18.90	6.00	—	3.15	.50	.75	.30	.30	10.00
7½ inch	AND	29.40	7.10	—	4.20	.50	.75	.50	.50	10.00
8¼ inch	BACK	31.50	8.40	—	5.25	.50	.75	.50	.50	10.00
9 inch		36.75	8.40	—	6.30	.50	.75	.50	.50	10.00
10 inch	PLATES	52.50	11.55	\$1.60	6.30	.50	.75	Inside Diam. .60	Outside Diam. .50	20.00
12 inch	MUST BE	71.40	13.60	1.60	10.50	.50	.75	Inside Diam. .75	Outside Diam. .50	20.00
15 inch	FITTED	99.75	16.80	2.60	16.80	.50	1.00	Inside Diam. 1.00	Outside Diam. .75	20.00
18 inch	AT	189.00	27.30	2.60	16.80	.50	1.00	Inside Diam. 1.00	Outside Diam. .75	20.00
21 inch	FACTORY	280.00	30.00	2.60	20.00	1.00	2.00	Inside Diam. 2.00	Outside Diam. 2.00	20.00
24 inch		375.00	35.00	2.60	20.00	1.00	2.00	Inside Diam. 2.00	Outside Diam. 2.00	20.00

★When ordering parts — we must have number appearing on chuck face.

4 JAW INDEPENDENT CHUCKS

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MEDIUM DUTY		
CHUCK NO.	CHUCK DIAMETER	PRICE
1306	6"	\$ 86.00
1308	8"	113.00
1310	10"	161.00
1312	12"	204.00
1315	15"	269.00
1318	18"	344.00
6421R†	21"	690.00
6424R†	24"	800.00
LIGHT DUTY		
CHUCK NO.	CHUCK DIAMETER	PRICE
1144	4"	\$ 59.00
1164	6"	69.00
1284	8"	91.00
1104	10"	116.00

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MEDIUM DUTY			
TYPES A-1 and A-2	PRICE EACH	TYPE D-1	PRICE EACH
1306A5	\$ 126.00	1306D3	\$ 132.00
1308A6	169.00	1306D4	132.00
1310A6	217.00	1308D6	188.00
1310A8	257.00	1310D6	236.00
1312A6	285.00	1310D8	256.00
1312A8	304.00	1312D6	289.00
1315A8	374.00	1312D8	309.00
1315A11	395.00	1315D6	374.00
1318A8	449.00	1315D8	374.00
1318A11	470.00	1318D6	449.00
6421RA11	880.00	1318D8	449.00
6421RA15	940.00		
6424RA11†	990.00		
6424RA15†	1,050.00		

MEDIUM DUTY — TYPE L

TYPE L	PRICE EACH	TYPE L	PRICE EACH
1306L-00	\$ 116.00	1315L-0	\$ 332.00
1306L-0	121.00	1315L-1	363.00
1308L-00	150.00	1315L-2	400.00
1308L-0	157.00	1318L-0	407.00
1310L-00	198.00	1318L-1	438.00
1310L-0	205.00	1318L-2	475.00
1310L-1	226.00	6421R-L-2†	910.00
1312L-0	258.00	6421R-L-3†	980.00
1312L-1	269.00	6424R-L-2†	1020.00
1312L-2	339.00	6424R-L-3†	1090.00

†Shown in Catalog 66. To be available Fall, 1967.

Independent chucks for spindle types not shown are available. Request quote.

LIGHT DUTY

TYPES A-1 and A-2	PRICE EACH	TYPE D-1	PRICE EACH
1284A5	\$ 137.00	1144D3	\$ 94.00
1104A5	162.00	1164D3	104.00
1104A6	182.00	1284D3	131.00
		1284D4	141.00
		1104D4	166.00

LIGHT DUTY — TYPE L

TYPE L	EACH PRICE
1164L-00	\$ 97.00
1284L-00	116.00
1104L-00	141.00

Threaded mounting plates for Independent Chucks only.

MEDIUM DUTY

MOUNTING NUMBER	CHUCK NUMBER	SPINDLE THREAD	PRICE EACH
T-1041	1306	1½"-8	\$ 12.00
T-1042	1306	1¾"-8	12.00
T-1043	1306	2¼"-8	12.00
T-1022	1306	2¾"-6	18.00
T-1031	1306	semi-finished	6.00
T-1030	1308 or 1310	2¼"-8	15.00
T-1029	1308 or 1310	2¾"-6	20.00
T-1028	1308 or 1310	2¾"-8	20.00
T-1027	1308 or 1310	semi-finished	9.00
T-1026	1312	2¼"-8	50.00
T-1025	1312	2¾"-6	50.00
T-1024	1312	2¾"-8	50.00
T-1023	1312	semi-finished	25.00
T-1004	1315 or 1318	semi-finished	90.00
T-1005	6421R or 6424R	semi-finished	100.00

LIGHT DUTY

MOUNTING NUMBER	CHUCK NUMBER	SPINDLE THREAD	PRICE EACH
T-1032	1144 or 1164	1"-8	\$ 15.00
T-1033	1144 or 1164	1"-10	15.00
T-1034	1144 or 1164	1"-12	15.00
T-1035	1144 or 1164	1½"-8	15.00
T-1036	1144 or 1164	1¾"-8	15.00
T-1037	1144 or 1164	2¼"-8	15.00
T-1038	1144 or 1164	semi-finished	4.50
T-1050	1284 or 1104	1½"-8	12.50
T-1051	1284 or 1104	1¾"-8	12.50
T-1055	1284 or 1104	2¼"-8	12.50
T-1058	1284 or 1104	2¾"-6	12.50
T-1059	1284 or 1104	semi-finished	6.00

PARTS FOR INDEPENDENT CHUCKS★

MEDIUM DUTY

CHUCK NUMBER	JAW EACH	SCREW EACH	T-BEARING EACH	WRENCH EACH
1306	\$ 6.00	\$ 2.00	\$ 2.00	\$ 4.00
1308	9.00	2.00	2.00	4.00
1310	10.00	4.00	2.00	5.00
1312	12.00	5.00	3.00	8.00
1315 or 1318	24.00	20.00	5.00	15.00
6421R or 6424R	on request	20.00	5.00	20.00

LIGHT DUTY

CHUCK NUMBER	JAW EACH	SCREW EACH	T-BEARING EACH	WRENCH EACH
1144	\$ 5.00	\$ 2.00	\$ 1.50	\$ 2.75
1164	5.00	2.00	1.50	2.75
1284	5.00	2.00	2.00	3.50
1104	5.50	2.00	2.00	4.00

★When ordering parts — We must have number appearing on chuck face.

POWER CHUCKS

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Meehanite body, steel front plate. Tongue and groove master jaws.

CHUCK NO. 3-JAW	DIA.	CHUCK NO. 2-JAW	PRICE
4006 replaces 106	6½"	4306 replaces 126	\$ 407.00
4008 replaces 108	8¼"	4308 replaces 128	494.00
4010 replaces 110	10"	4310 replaces 130	580.00
4012 replaces 112	12"	4312 replaces 132	660.00
4015	15"	4315	780.00
4018	18"	4318	980.00
4021†	21"	Request quote	1,500.00
4024†	24"	Request quote	1,900.00

†Shown in Catalog 66. To be available Summer, 1967.

Aluminum body, steel front plate. Tongue and groove master jaws.

CHUCK NO. 3-JAW	DIA.	CHUCK NO. 2-JAW	PRICE
4106 replaces 166	6½"	4406 replaces 167	\$ 437.00
4108 replaces 168	8¼"	4408 replaces 169	524.00
4110 replaces 170	10"	4410 replaces 171	610.00
4112 replaces 172	12"	4412 replaces 173	690.00
4115 replaces 175	15"	4415 replaces 177	810.00
4118 replaces 178	18"	4418 replaces 179	1,100.00

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Meehanite body, steel front plate. Square serrated master jaws.

CHUCK NO. 3-JAW	DIA.	CHUCK NO. 2-JAW	PRICE
5510	10"	5410	\$ 680.00
5512	12"	5412	760.00
5515	15"	5415	970.00
5518	18"	5418	1,140.00
5521†	21"	Request quote	1,700.00
5524†	24"	Request quote	2,100.00

†Shown in Catalog 66. To be available Summer, 1967.

Aluminum body, steel front plate. Square serrated master jaws.

CHUCK NO. 3-JAW	DIA.	CHUCK NO. 2-JAW	PRICE
6310	10"	6210	\$ 710.00
6312	12"	6212	790.00
6315	15"	6215	1,000.00
6318	18"	6218	1,170.00

Square Serrated Chuck

MASTER KEYS

CHUCK DIAM.	PART NO.	PRICE EACH	PART NO.	PRICE EACH
10"	11445	\$ 9.00	13788	\$10.00
12"	11445	9.00	13788	10.00
15"	11449	12.00	11450	15.00
18"	11449	12.00	11450	15.00
21"	11449	12.00	11450	15.00
24"	11449	12.00	11450	15.00

To Use Am. Std. Serrated Top Jaws on Super-Life Chucks with Square Serrated Master Jaws.

CHUCK DIAM.	MASTER KEY NO.	PRICE EACH	NUT NO. JAW	PRICE EACH
10"	13786	\$12.00	13789	\$16.00
12"	13786	12.00	13790	16.00
15"	11449-1	16.00	11450-1	24.00
18"	11449-1	16.00	11450-1	24.00

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"PULL-BACK" POWER CHUCKS — EXTERNAL

THREE-JAW	TWO-JAW	DIA.	PRICE
3706-A5	3806-A5	6½"	\$ 590.00
3708-A5	3808-A5	8¼"	720.00
3708-A6	3808-A6	8¼"	720.00
3710-A6	3810-A6	10"	840.00
3710-A8	3810-A8	10"	840.00
3712-A6	3812-A6	12"	930.00
3712-A8	3812-A8	12"	930.00
3715-A11	—	15"	1250.00
3718-A11	—	18"	1650.00
3721-A11	—	21"	1950.00
3721-A15	—	21"	1950.00
3724-A11	—	24"	2200.00
3724-A15	—	24"	2200.00

"PULL-BACK" POWER CHUCKS — INTERNAL

THREE-JAW	TWO-JAW	DIA.	PRICE
3906	4206	5 $\frac{7}{8}$ "	\$ 675.00
3907	4207	7 $\frac{1}{2}$ "	820.00
3908	4208	7 $\frac{7}{8}$ "	820.00
3910	4210	9 $\frac{1}{2}$ "	950.00
3912	4212	12"	1050.00

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FOR "SUPER-LIFE" AND "PULL-BACK" CHUCKS

Soft Top Jaws — Standard Height. Tongue and Groove Type, 2 or 3 Jaw.

CHUCK DIAMETER	PART NO.	PRICE
6 $\frac{1}{2}$ "	10073	\$ 3.25
8 $\frac{1}{4}$ "	10184	3.75
10"	10047	4.00
12"	10002	4.75
15"-18"	11351	8.50
21"-24"	—	on application

Long Pointed Soft Top Jaws — Standard Height. Tongue and Groove Type.

CHUCK DIAMETER	3 JAW (Ptd.) PART NO.	2 JAW (Sq. Ends) PART NO.	PRICE EACH
6 $\frac{1}{2}$ "	10073-19	10073-20	\$ 4.00
8 $\frac{1}{4}$ "	10184-7	10184-8	4.25
10"	10047-9	10047-10	6.50
12"	10002-11	10002-12	7.50
15"-18"	11351-3	11351-2	11.50

Long Pointed Soft Top Jaws — Extra Height. Tongue and Groove Type.

CHUCK DIAMETER	3 JAW (Ptd.) PART NO.	2 JAW (Sq. Ends) PART NO.	PRICE EACH
6 $\frac{1}{2}$ "	10073-17	10073-18	\$ 5.50
8 $\frac{1}{4}$ "	10184-5	10184-6	6.00
10"	10047-11	10047-12	7.50
12"	10002-9	10002-10	9.50
15"-18"	11351-4	11351-5	12.00

Soft Top Jaws — Standard Height. Serrated Power Chuck Type

CHUCK DIAMETER	SQUARE SER. PART NO.	PRICE EACH
10"	13047-20	\$ 7.50
12"	13047-1	8.00
15"-18"	11505-1	12.00
21"-24"	—	on application

Round One-Bolt Soft Top Jaws for External "Pull Back" Power Chucks.

CHUCK DIAMETER	PART NUMBER	PRICE EACH
8 $\frac{1}{4}$ " and fractional 7"	12647-3	\$ 3.75
10" Std.	13856-9	4.00
10" X-High	13856-8	6.50
12" Std.	13856-9	4.75
12" X-High	13856-8	9.50
15"-18"-21"-24" Std.	13759-8	8.50
15"-18"-21"-24" X-High	13759-9	12.00

JAW TURNING FIXTURES

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TONGUE AND GROOVE TYPE

For "Super-Life" and External "Pull Back" chucks.

CHUCK DIAMETER	FIXTURE NUMBER	PRICE
5 $\frac{3}{4}$ "-6 $\frac{1}{2}$ "	1049	\$ 160.00
8 $\frac{1}{4}$ "	1050	180.00
10"	1051	200.00
12"	1052	240.00
15"	1055	375.00
18"	1058	480.00

SQUARE SERRATED TYPE

For "Super-Life" chucks.

CHUCK DIAMETER	FIXTURE NUMBER	PRICE
10"	1063	\$ 260.00
12"	1061	260.00
15"	1060	400.00
18"	1059	510.00

INTERNAL "PULL BACK" CHUCKS

CHUCK DIAMETER	FIXTURE NUMBER	PRICE
5 $\frac{7}{8}$ "	1049 Out Pos.	\$ 160.00
7 $\frac{1}{2}$ "		on application
7 $\frac{7}{8}$ "	1050 In Pos.	180.00
9 $\frac{1}{2}$ "		on application
12"		on application

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AIR CYLINDERS AND ADAPTERS (Unfitted)

CYL NO.	CYL SIZE	PRICE	ADAPTER NO.	CYL SIZE	PRICE
1604	4 $\frac{1}{4}$ "	\$ 195.00	1004	4 $\frac{1}{4}$ "	\$ 40.00
1606	6"	225.00	1006	6"	40.00
1608	8"	275.00	1006	8"	40.00
1610	10"	355.00	1010	10"	55.00
1612	12"	440.00	1010	12"	55.00
1614	14"	620.00	1010	14"	55.00
Average fitting charge					\$ 70.00

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Air unit complete (filter, lubricator, regulating valve and gauge).

Part No. 1044 — For 4 $\frac{1}{2}$ ", 6" and 8" Cylinder	\$ 45.00
Part No. 1045 — For 10", 12" and 14" Cylinder	45.00

Hand operated valves.

VAVLE NO.	PIPE-SIZE	PRICE
1046 — For 4 $\frac{1}{2}$ ", 6" & 8" Cyl.	1 $\frac{1}{4}$ "	\$ 30.00
1047 — For 10", 12" & 14" Cyl.	3 $\frac{3}{8}$ "	35.00

Draw Tube — Specify: Chuck No., Machine Make, Model Number, and Spindle Length. on application

Draw Bar No. 1040.

6 $\frac{1}{2}$ " - 12" chucks	\$ 30.00
15" - 24" chucks	50.00

Specify: Chuck No., Machine Make, Model Number, and Spindle Length.

Extension Tube on application
Specify: Chuck No., Machine Make, Model Number, and Spindle Length

DISTRIBUTED BY

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